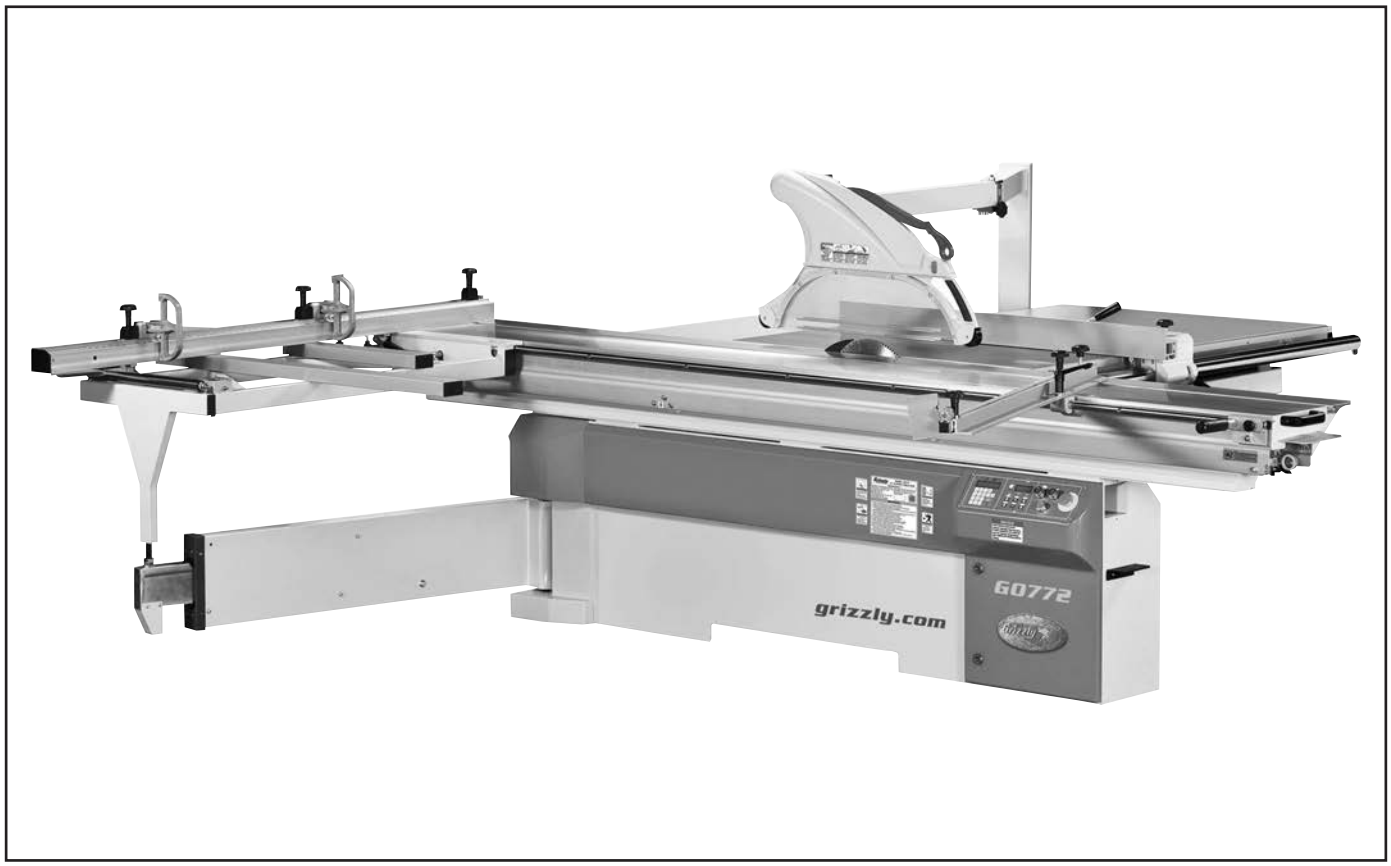
Grizzly Industrial, Inc.®

MODEL G0772
14" SLIDING TABLE SAW
OWNER'S MANUAL
(For models manufactured since 09/14)



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⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

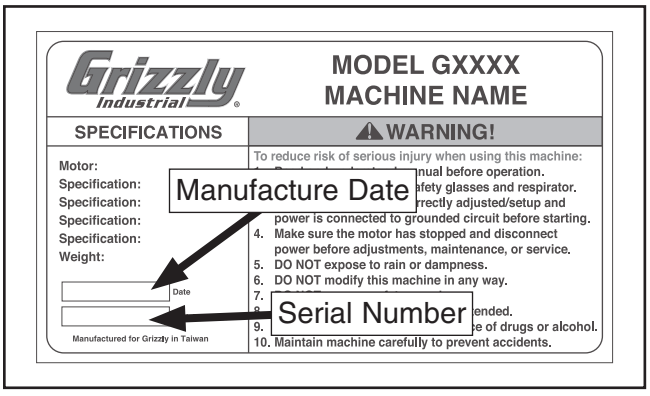
Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual**.

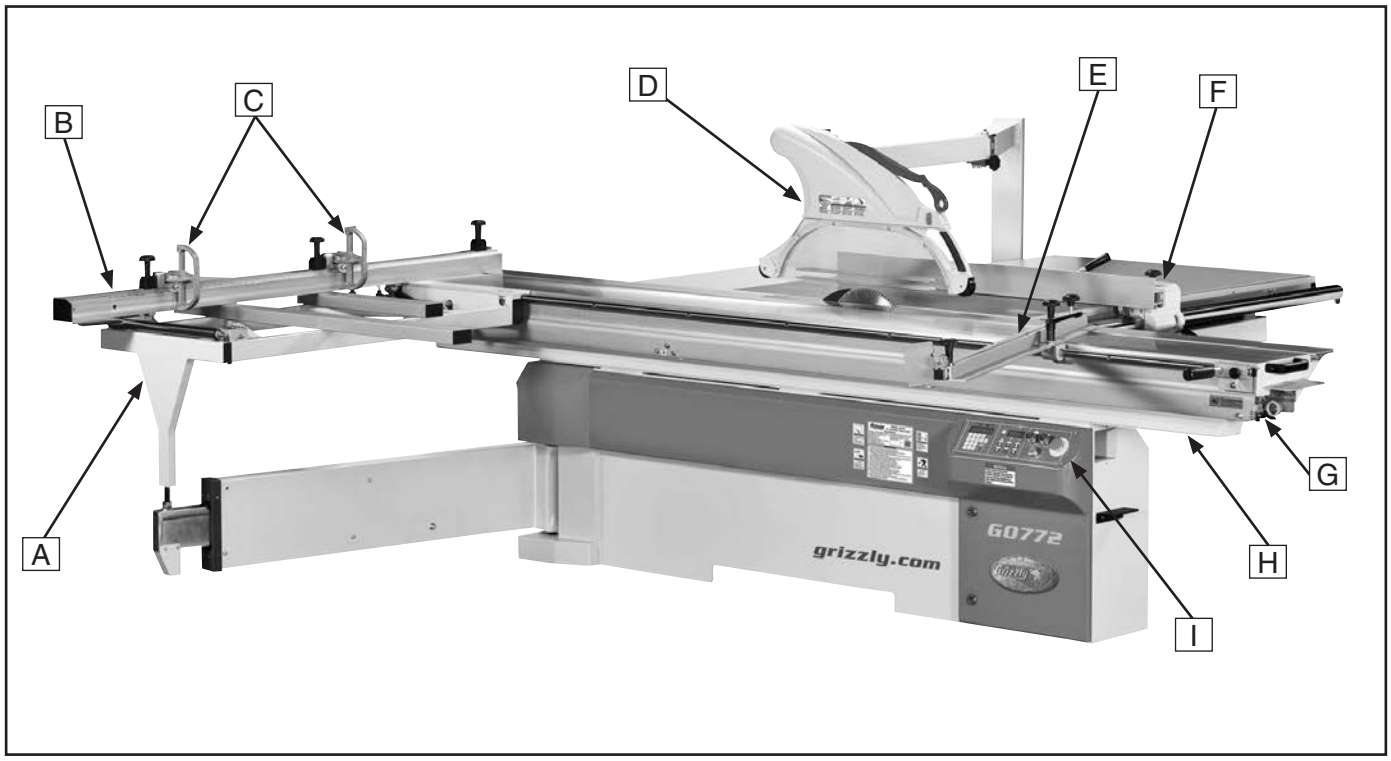
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.



Identification

Become familiar with the names and locations of the controls and components shown below to better understand the instructions in this manual.



A. Crosscut Table. Provides a wide, stable platform for supporting full-size panels during crosscutting operations.

B. Crosscut Fence. Used during crosscutting operations to keep panels at 90˚ angle to blade. Features a scale and flip stops.

C. Flip Stops. Used for quick, precise measurements for repeatable cuts when using crosscutting fence.

D. Blade Guard. Fully-enclosed, adjustable blade guard maintains maximum protection around saw blade with a 3" dust port that effectively extracts dust from cutting operation.

E. Miter Fence. Allows precise miter cuts from 30˚left to 45˚ right.

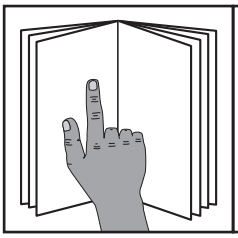
F. Rip Fence. Fully-adjustable with micro-adjust knob for precision cuts. Fence face can be positioned for standard cutting operations, or placed in lower position for blade guard clearance during narrow ripping operations.

G. Sliding Table Lever. Allows sliding table to be locked in stationary position. Push down to release; pull up to lock.

H. Sliding Table. Ball-bearing rollers make it quick and easy to guide large, heavy panels through cut.

I. Control Panel. Features push-button controls for operating saw.

Controls & Components



⚠WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

Refer to **Figures 1–6** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this saw.

Rip Fence

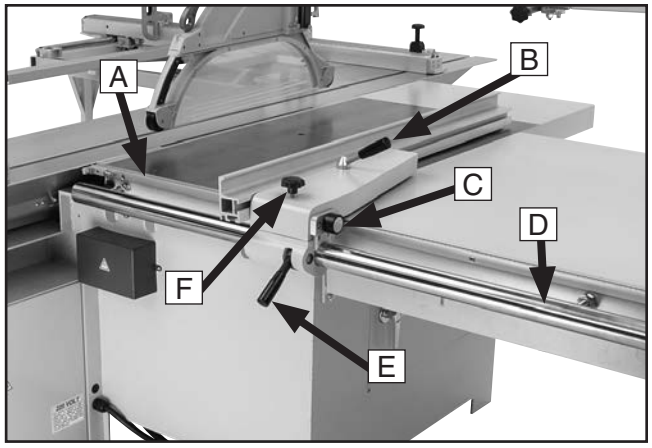


Figure 1. Rip fence controls.

A. Rip Fence Scale. Helps measure cut during ripping operations. Features a dual-calibration block to ensure scale is easy to read whether fence is in high or low position.

B. Slide Lock Handle. Secures aluminum fence face on its forward/backward slide track.

C. Micro-Adjust Knob. Provides precise adjustment of fence. Loosen micro-adjust lock knob to use this feature.

D. Rip Fence Rail. Provides a stable side-to-side path for sliding rip fence assembly toward or away from blade.

E. Rip Fence Lock Handle. Secures rip fence assembly in position along fence rail so workpiece is stable when cutting.

F. Micro-Adjust Lock Knob. Enables use of micro-adjust knob for precise positioning of rip fence.

Miter Fence

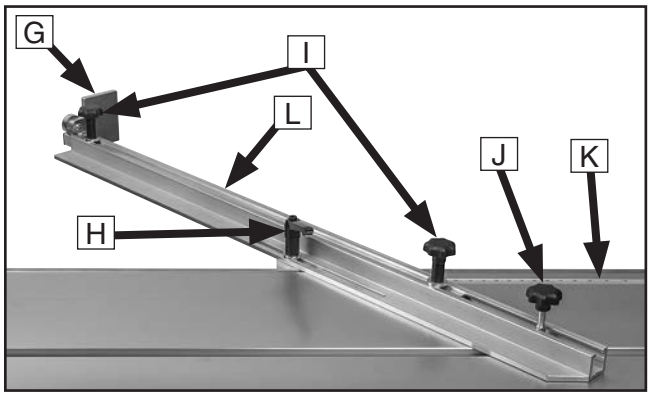


Figure 2. Miter fence controls.

G. Flip Stop. Used for quick, precise measurements for repeatable cuts when using miter fence.

H. Clamp Plate Ratcheting Handle. Locks miter fence in position once desired angle is determined.

I. Lock Knobs. Secure position of aluminum slide bar in miter fence.

J. Pivot Knob. Secures miter fence to sliding table T-slot.

K. Miter Fence Scale. Helps measure angle of cut during miter operations. Features resolution of ½˚.

L. Aluminum Slide Bar: Adjusts to extend or shorten length of miter fence.

Control Panel

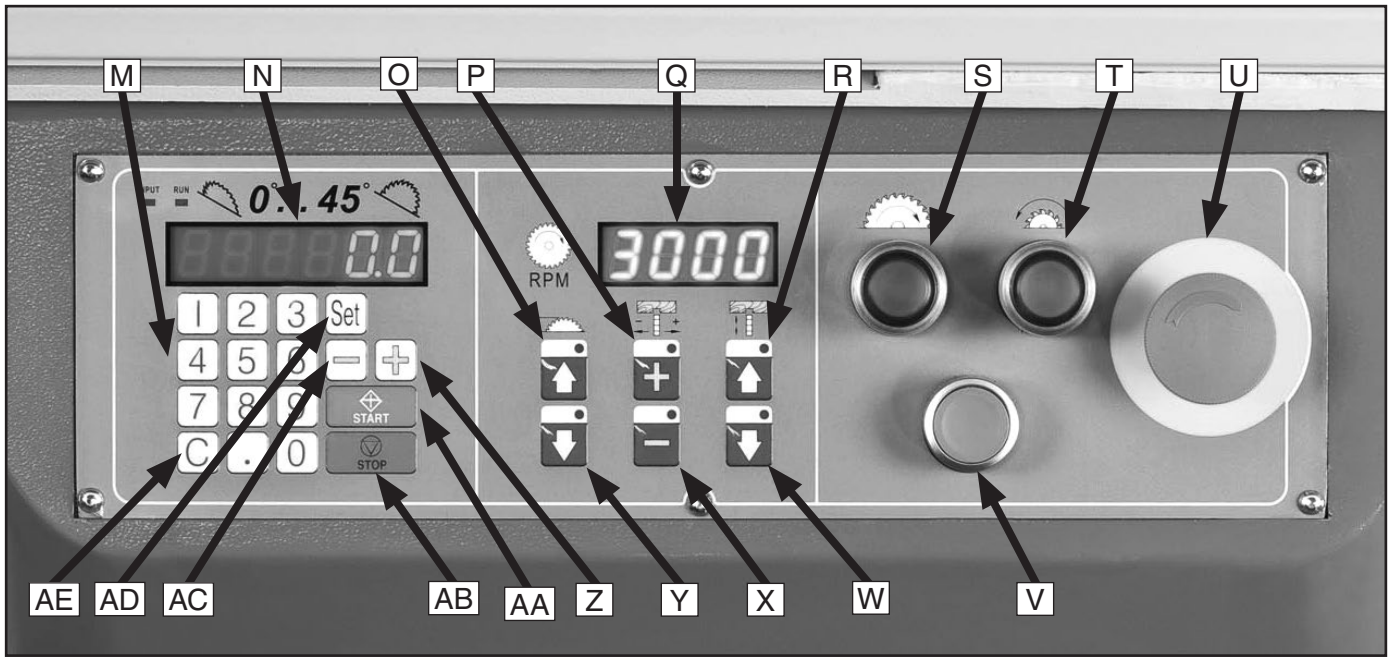


Figure 3. Control panel functions.

M. Keypad. For entering desired angle of saw blades.

N. Blade Angle Display. Displays current angle of saw blades.

O. Main Blade *Up* Key. Increases height of main saw blade.

P. Scoring Blade *Left* Key. Moves scoring blade left to align with main blade.

Q. Arbor RPM Display. Displays current RPM of saw blade.

R. Scoring Blade *Up* Key. Increases height of scoring blade.

S. Main Blade ON Button. Enables power to main blade.

T. Scoring Blade ON Button. Enables power to scoring blade.

U. Emergency Stop Button. Turns both motors ***OFF*** and disables control panel. To reset, twist clockwise until button pops out.

V. Motor OFF Button. Turns both motors ***OFF***.

W. Scoring Blade *Down* Key. Decreases height of scoring blade.

X. Scoring Blade *Right* Key. Moves scoring blade right to align with main blade.

Y. Main Blade *Down* Key. Decreases height of main saw blade.

Z. "+" Key. Manually increases angle of saw blades in increments of 0.1".

AA. Start Key. Starts trunnion movement after an angle has been entered.

AB. Stop Key. Stops trunnion movement.

AC. "-" Key. Manually decreases angle of saw blades in increments of 0.1".

AD. Set Key. Sets blade angles entered into keypad. Also used for calibration.

AE. "C" Key. Clears typed entries in display.

Saw Blades

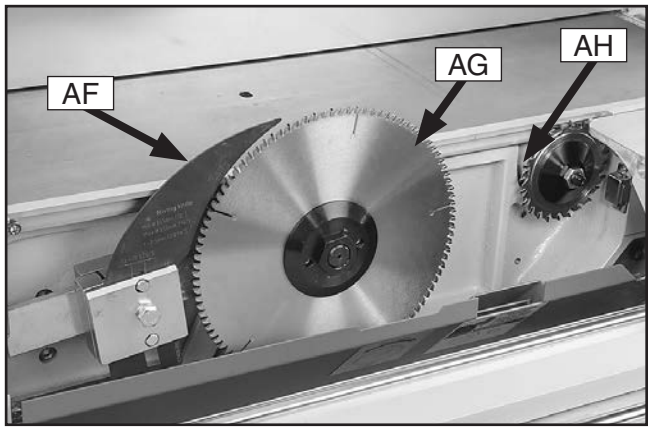


Figure 4. Saw blades.

AF. Riving Knife. Maintains kerf opening during cutting operations. This function is crucial to preventing kickback caused by kerf closing behind blade.

AG. Main Blade. Performs cutting operation.

AH. Scoring Blade. Rotates in opposite direction of main blade and pre-cuts surface of workpiece before actual cutting operation is performed to reduce tearout or chipping. Scoring blade is adjustable for kerf thickness and alignment with main blade.

Blade Guard

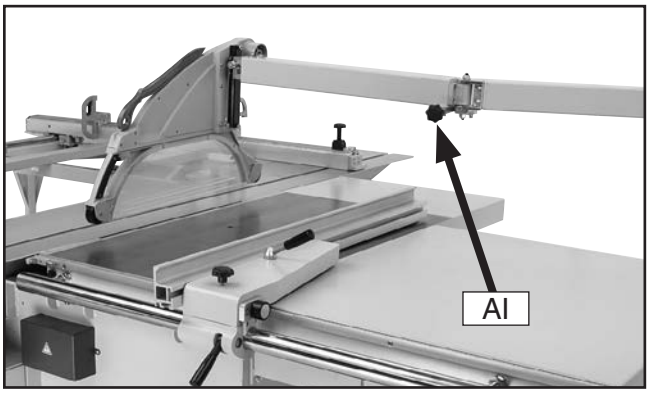


Figure 5. Blade guard components.

AI. Lock Knob. When loosened, allows blade guard support arm to swing out of the way.

Master Power

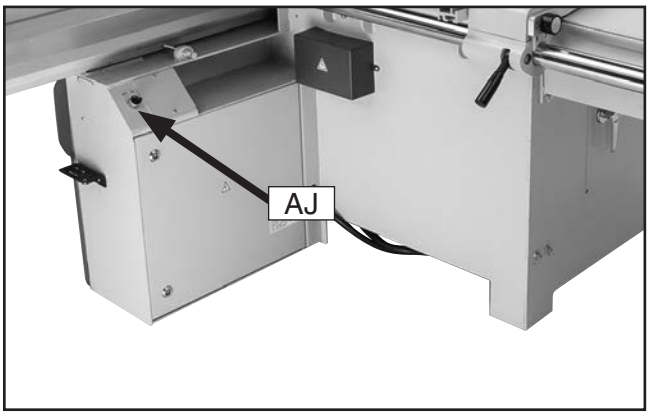


Figure 6. Location of master power switch.

AJ. Master Power Switch. Enables power flow to machine.

Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this sliding table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is VERY important to us at Grizzly!

Arbor: Metal shaft extending from the drive mechanism, to which saw blade is mounted.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

Blade Guard: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

Crosscut: Cutting operation in which the crosscut fence is used to cut across the grain, or across the shortest width of the workpiece.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that cuts a flat bottomed groove into the face of the workpiece.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface.

Kerf: The resulting cut or gap in the workpiece from the saw blade passing through it while cutting.

Kickback: A dangerous event that happens if the blade catches on the workpieces while cutting. The force of the blade then throws the workpiece back toward the operator with what sounds like a horrible explosion. The danger comes from flying stock striking the operator or bystanders. The operator's hands may also be pulled into the blade during the kickback. Refer to **Preventing Kickback** on **Page 15** for additional information.

Non-Through Cut: A sawing operation in which the workpiece is not completely sawn through. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock.

Parallel: When two objects are spaced an equal distance apart at every point along two given lines or planes (I.e. the rip fence face is parallel to the face of the saw blade).

Perpendicular: Lines or planes that intersect and form right angles. I.e. the blade is perpendicular to the table surface.

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece.

Rip Cut: Cutting operation in which the rip fence is used to cut with the grain, or cut across the widest width of the workpiece.

Riving Knife: Metal plate located behind the blade maintains the kerf opening in the wood when cutting, and helps reduce the risk of injury from a kickback that otherwise would result in amputation.

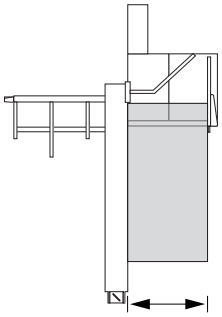
Straightedge: A tool with a perfectly straight edge used to check the flatness, parallelism, or consistency of a surface(s).

Through Cut: A sawing operation in which the workpiece is completely sawn through.

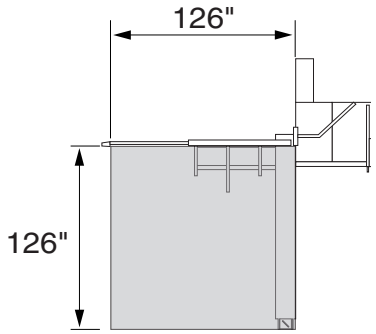
SLIDING TABLE SAW CAPACITIES

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

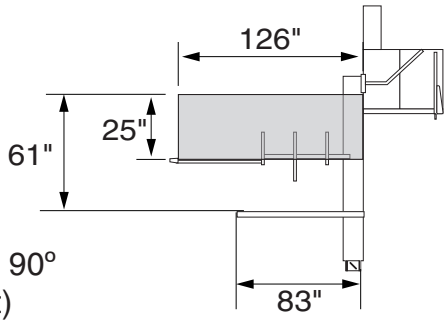
MODEL G0772 14" SLIDING TABLE SAW



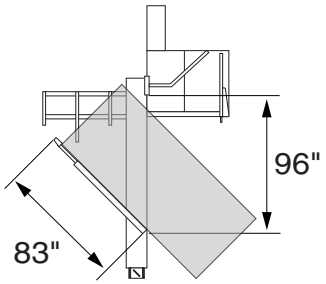
Ripping Width



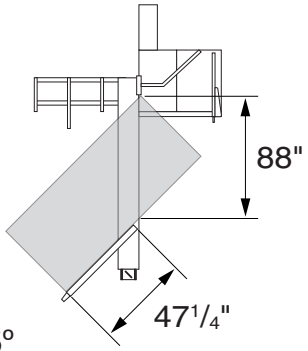
Cross Cut



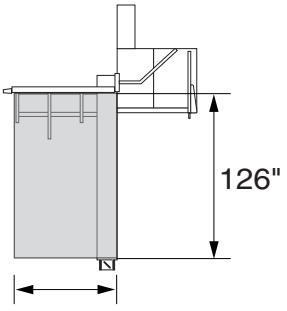
Miter Cut 90°
(push cut)



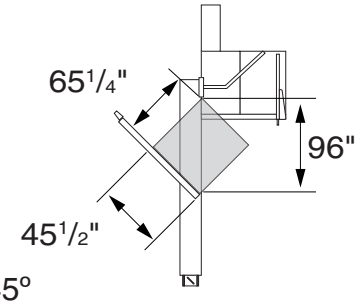
Miter Cut 45°
(push cut)



Miter Cut 45°



Cross Cut
(fence not extended)



Miter Cut 45°
(push cut, fence not extended)

(NO CAPACITY)

Miter Cut 45°
(fence not extended)

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0772 14" SLIDING TABLE SAW

Product Dimensions:

Weight..... 2486 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 132 x 130 x 55 in.
Footprint (Length x Width)..... 64-1/2 x 39 in.
Space Required for Full Range of Movement (Width x Depth)..... 276 x 195 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
Content..... Machine
Weight..... 2389 lbs.
Length x Width x Height..... 90 x 52 x 44 in.
Must Ship Upright..... Yes

Carton #2

Type..... Wood Crate
Content..... Sliding Table
Weight..... 543 lbs.
Length x Width x Height..... 132 x 19 x 14 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
Prewired Voltage..... 220V
Full-Load Current Rating..... 28A at 220V, 14A at 440V
Minimum Circuit Size..... 40A at 220V, 20A at 440V
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Switch Type..... Control Panel w/Magnetic Switch Protection

Motors:

Main

Type..... TEFC Induction
Horsepower..... 10 HP
Phase..... 3-Phase
Amps..... 25A/12.5A
Speed..... 3450 RPM
Power Transfer ..... Belt Drive
Bearings..... Shielded & Permanently Lubricated

Scoring Blade

Type..... TEFC Induction
Horsepower..... 1 HP
Phase..... 3-Phase
Amps..... 3A/1.5A
Speed..... 3450 RPM
Power Transfer ..... Flat-Belt Drive
Bearings..... Shielded & Permanently Sealed

Main Specifications:

Operation Information

Main Blade Size	14 in.
Riving Knife/Spreader Thickness	0.098 in.
Required Blade Body Thickness	0.108 in.
Required Blade Kerf Thickness	0.108 in.
Main Blade Arbor Size	1 in.
Scoring Blade Size	120mm (4-3/4 in.)
Scoring Blade Arbor Size	22 mm
Main Blade Tilt	0 – 45 deg.
Main Blade Speed	3000, 4000, 5000, 6000 RPM
Scoring Blade Tilt	0 – 45 deg.
Scoring Blade Speed	8000 RPM

Cutting Capacities

Max Depth of Cut At 90 Deg	4 in.
Max Depth of Cut At 45 Deg	2-3/4 in.
Max Dist From Blade To Column	60 in.
Rip Fence Max Cut Width	52-1/2 in.
Sliding Table w/Crosscut Fence Max Cut Width	126 in.
Sliding Table w/Crosscut Fence Max Cut Length	126 in.
Miter Fence Max Cut Width at 45 Deg	97 in.

Table Information

Floor To Table Height	35 in.
Table Size Length	39-1/4 in.
Table Size Width	34-1/2 in.
Table Size Thickness	3 in.
Table Size With Ext Wings Length	60 in.
Table Size With Ext Wings Width	59-1/4 in.
Table Size With Ext Wings Thickness	3 in.
Sliding Table Length	126 in.
Sliding Table Width	15 in.
Sliding Table Thickness	8-5/8 in.
Sliding Table T-Slot Top Width	7/8 in.
Sliding Table T-Slot Height	3/4 in.
Sliding Table T-Slot Bottom Width	7/8 in.

Fence Information

Crosscut Fence Type	Extruded Aluminum w/Telescoping End
Crosscut Fence Size Length	70 in.
Crosscut Fence Size Max Extended Length	126-1/2 in.
Crosscut Fence Size Width	3-1/4 in.
Crosscut Fence Size Height	2-3/4 in.
Crosscut Fence Number of Stops	2
Rip Fence Type	2-Position Single-Lever Locking w/Micro Adjustment
Rip Fence Size Length	47-1/4 in.
Rip Fence Size Width	2 in.
Rip Fence Size Height	3-5/8 in.
Miter Fence Type	T-Slot Mounted Aluminum Tube
Miter Fence Size Length	47-1/4 in.
Miter Fence Size Max Extended Length	83 in.
Miter Fence Size Width	3-1/8 in.
Miter Fence Size Height	1-1/2 in.
Miter Fence Number of Stops	1

Construction Materials

Table	Cast Iron
Sliding Table	Aluminum
Extension Table	Steel
Cabinet	Steel
Rip Fence	Aluminum
Miter Fence	Aluminum
Rip Fence Rails	Chromed Steel
Guard	Plastic
Spindle Bearing Type	Sealed & Permanently Lubricated
Cabinet Paint Type/Finish	Urethane

Other Related Information

No of Dust Ports	2
Dust Port Size	3, 5 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	5 Hours
Serial Number Location	ID Label on Right Side of Electrical Control Box
ISO 9001 Factory	No
CSA, ETL, or UL Certified/Listed	No

Features:

Cross-Slide Table with Eccentric Locking Clamp and Hard Chrome-Plated Slide-Way
Easily Adjustable Saw Guard with Built-In Dust Hood
Miter Fence Adjustable 30 Degrees Left and 45 Degrees Right
Push-Button Digital Control of Blade Speed, Height Adjustments, Blade Tilt, and Scoring Blade Alignment
Scoring Blade Virtually Eliminates Tear-Out
Sliding Table on Vertical Guide System with Precision Bearing Rollers
Accepts 12" and 14" Blades

SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

Safety Instructions for Machinery

⚠WARNING

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.

⚠WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine ***OFF*** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

Additional Safety for Sliding Table Saws

⚠WARNING

Serious injury or death can occur from getting cut or having body parts, such as fingers, amputated by rotating saw blade. Workpieces thrown by kickback can strike operators or bystanders with deadly force. Flying particles from cutting operations or broken blades can cause eye injuries or blindness. To minimize risk of getting hurt or killed, anyone operating machine MUST completely heed hazards and warnings below.

HAND & BODY POSITIONING. Keep hands away from saw blade and out of blade path during operation, so they cannot slip accidentally into blade. Stand to side of blade path. Never reach around, behind, or over blade. Only operate at front of machine.

BLADE GUARD. Use blade guard for all cuts that allow it to be used safely. Make sure blade guard is installed and adjusted correctly. Promptly repair or replace if damaged. Re-install blade guard immediately after operations that require its removal.

RIVING KNIFE. Use riving knife for all cuts. Make sure riving knife is aligned and positioned correctly. Promptly repair or replace it if damaged.

KICKBACK. Kickback occurs when saw blade ejects workpiece back toward operator. Know how to reduce risk of kickback. Learn how to protect yourself if it does occur.

WORKPIECE CONTROL. Feeding workpiece incorrectly increases risk of kickback. Make sure workpiece is in stable position on tables and supported by rip fence or crosscut fence during cutting operation. Never start saw with workpiece touching blade. Allow blade to reach full speed before cutting. Only feed workpiece against direction of main blade rotation. Always use some type of guide to feed workpiece in a straight line. Never back workpiece out of cut or move it backwards or sideways after starting a cut. Feed cuts all the way through to completion. Never perform any operation "freehand". Turn OFF saw and wait until blade is completely stopped before removing workpiece.

FENCE ADJUSTMENTS. Make sure rip fence remains properly adjusted and parallel with blade. Always lock fence before using.

PUSH STICKS/BLOCKS. Use push sticks or push blocks whenever possible to keep your hands farther away from blade while cutting. In event of an accident these devices will often take damage that would have happened to hands/fingers.

BLADE ADJUSTMENTS. Adjusting blade height or tilt during operation increases risk of crashing blade and sending metal fragments flying with deadly force at operator or bystanders. Only adjust blade height and tilt when blade is completely stopped and saw is ***OFF***.

CHANGING BLADES. Always disconnect power before changing blades. Changing blades while saw is connected to power greatly increases injury risk if saw is accidentally powered up.

DAMAGED SAW BLADES. Never use blades that have been dropped or otherwise damaged.

CUTTING CORRECT MATERIAL. Never cut materials not intended for this saw. Only cut natural and man-made wood products, laminate covered wood products, and some plastics. Cutting metal, glass, stone, tile, etc. increases risk of operator injury due to kickback or flying particles.

Preventing Kickback

Do the following to prevent kickback:

- When rip cutting, only cut workpieces that have at least one smooth and straight edge. DO NOT cut excessively warped, cupped or twisted wood. If workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.
- Ensure sliding table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table before cutting.
- Always use the riving knife whenever possible. It reduces risk of kickback and reduces your risk of injury if it does occur.
- Always keep blade guard installed and in good working order.
- Feed cuts through to completion. Any time you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.
- Ensure rip fence is adjusted parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the rip fence before cutting.

⚠WARNING

Statistics show that the most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward the operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some precautions to help protect yourself if kickback DOES occur:

- Stand to the side of the blade path when cutting. If a kickback does occur, the thrown workpiece usually travels directly towards the front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable parts of your body.
- Never, for any reason, place your hand behind the blade path. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick or push block to keep your hands farther away from the moving blade. If a kickback occurs, these safety devices will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to prevent or slow down kickback.

SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.

⚠WARNING

Electrocution, fire, or equipment damage may occur if machine is not correctly grounded and connected to the power supply.

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V ..... 28 Amps
Full-Load Current Rating at 440V ..... 14 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Circuit Requirements for 220V

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V, 230V, 240V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 40 Amps

Circuit Requirements for 440V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 440V, 480V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 20 Amps

Connection Type

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

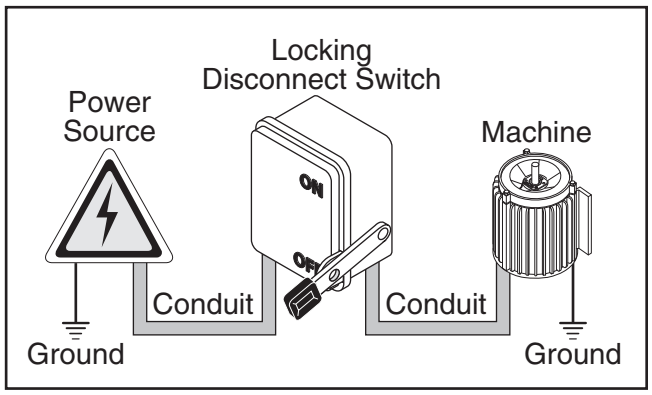


Figure 7. Typical setup of a permanently connected machine.

Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

⚠WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Extension Cords

Since this machine must be permanently connected to the power supply, an extension cord cannot be used.

Phase Converters

Avoid using a static phase converter to supply 3-Phase power for this machine, as it could damage or decrease the life of sensitive electrical components. If you must use a phase converter, only use a rotary phase converter that is sized at least 50% larger than the largest HP rating of this machine. If using a phase converter to supply power, only connect the manufactured leg or "wild wire" to the "S" terminal (see location on **Page 87**). The S terminal can handle power fluctuations because it is wired directly to the motor.

440V Conversion

The Model G0772 can be converted for 440V operation using the optional Part# P07721412. This can be purchased by contacting the Grizzly Order Desk at (800) 523-4777. This conversion job consists of: 1) replacing the overload relays and 2) rewiring the main and scoring blade motors for 440V operation.

All wiring changes must be done by an electrician or qualified service personnel before the saw is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

Before performing the conversion procedure, we recommend setting the blade to 0° and raising it all the way up to create clearance under the main and scoring motor junction boxes for rewiring.

To convert G0772 for 440V operation:

1. DISCONNECT MACHINE FROM POWER!

2. Open electrical panel door (see **Figure 8**).

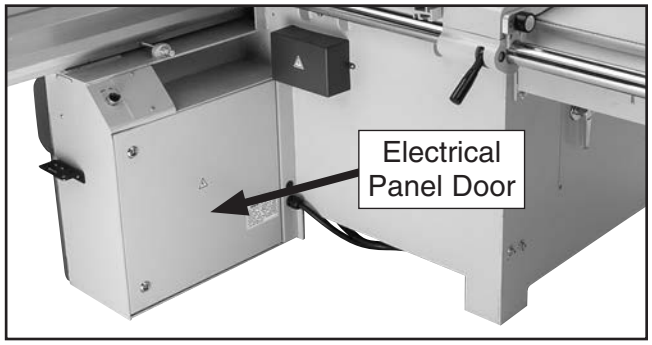


Figure 8. Location of electrical panel door.

3. Remove main motor overload relay for 220V. Replace with RHU-10/7.5K1 overload relay included with 440V Conversion Kit. Set overload dial to 6.5A (see **Figure 9**).

4. Remove scoring motor overload relay for 220V. Replace with RHU-10/2K1 overload relay included with 440V Conversion Kit. Set amperage dial to 1.6A (see **Figure 9**).

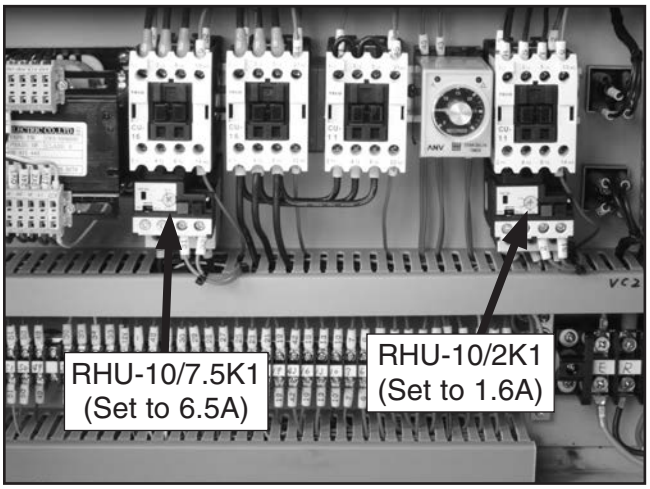


Figure 9. Overload relays from 440V Conversion Kit installed and set for specified trip current.

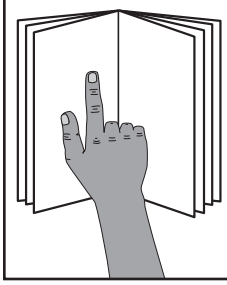
5. Close electrical panel door.

6. Open motor cabinet door on back of saw.

7. Rewire main blade and scoring blade motors to 440V. Refer to wiring diagrams on **Pages 93–92**.

8. Close motor cabinet door.

SECTION 3: SETUP

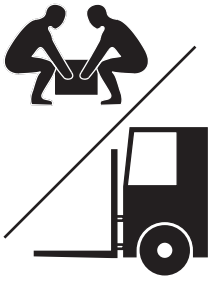


⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

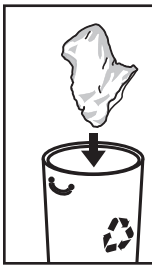
Description	Qty
• Additional People	4
• Safety Glasses	1 Per Person
• Cleaner/Degreaser (**Page 23**)	As Needed
• Disposable Shop Rags	As Needed
• Forklift (Rated for at least 3000 lbs.)	1
• Straightedge 4'	1
• Level	1
• Screwdriver Phillips #2	1
• Open-End Wrenches 13mm, 19mm	1 Ea
• Dust Collection System w/5" Branch Line	1
• Dust Hose & Hose Clamp 5"	1 Ea
• Dust Hose & Hose Clamp 3"	1 Ea
• Y-Fitting 3" x 5" x 5"	1
• Feeler Gauge Set	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

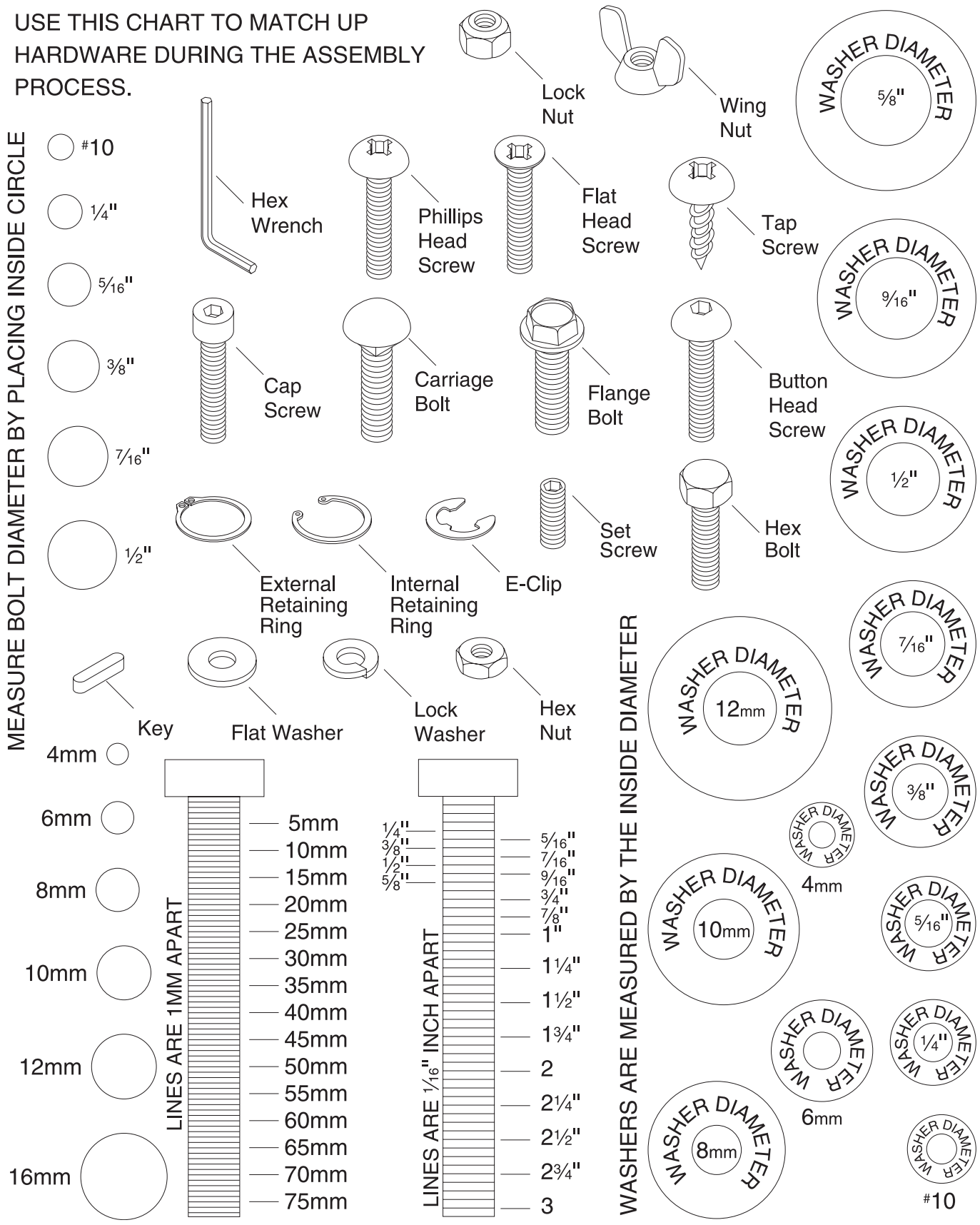


⚠WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

Hardware Recognition Chart



Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Crate 1 (Figure 10)	Qty
A. Saw Base Unit	1
B. Small Extension Table	1
C. Large Extension Table	1
D. Crosscut Table Frame	1
E. Large Extension Table Brace (L)	1
F. Large Extension Table Brace (R)	1
G. Rip Fence Rail w/Fasteners	1
—Hex Nuts M20-2.5	9
—Flat Washers 20mm	6
H. Rip Fence Base Assembly	1
I. Crosscut Fence Flip Stops	2
J. End Plate (Sliding Table)	1
K. End Handle (Sliding Table)	1
L. Push Handle	1
M. Push Stick	1
N. Flat Blade Guard Assembly	1
O. Bubble Blade Guard Assembly	1
P. Blade Guard Swing Arm	1
Q. Blade Guard Lower Support Arm	1
R. Blade Guard Upper Support Arm	1

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

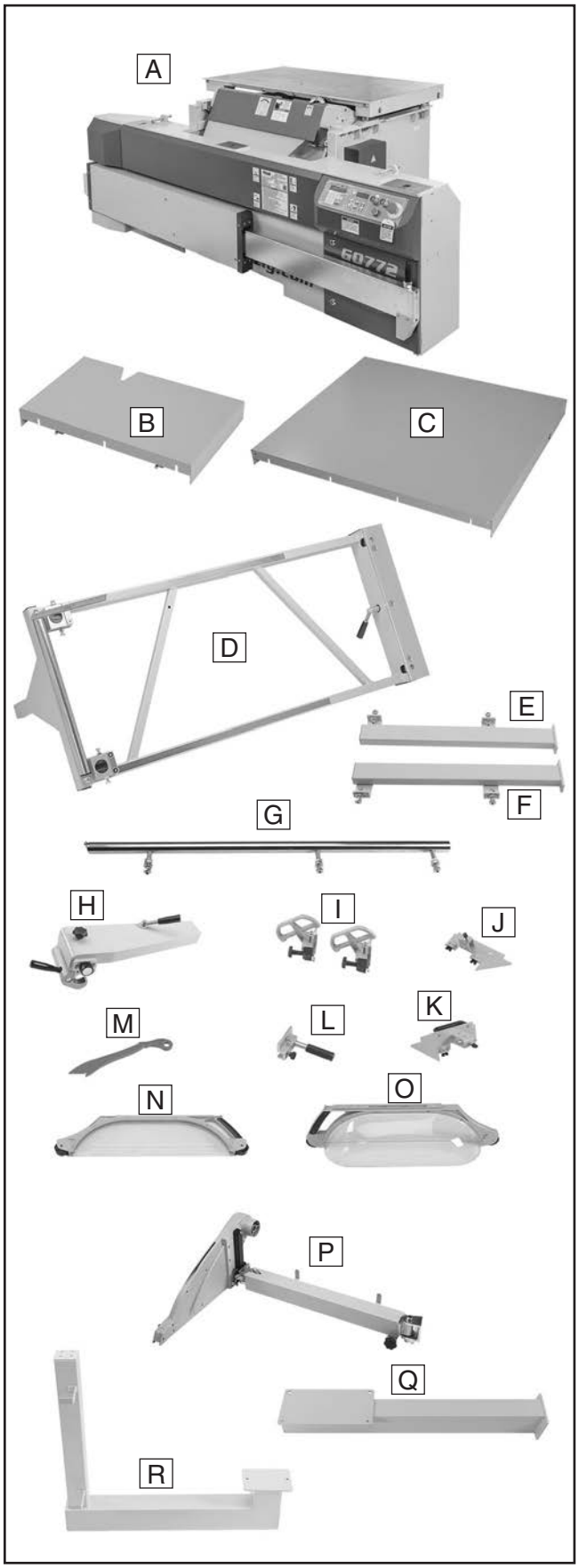


Figure 10. Crate 1 inventory.

Crate 1 Continued (Figure 11) **Qty**

S. Tool Box 1
T. Grease Gun 1
U. Riving Knife 1
V. Open-End Wrench 30 x 41mm 1
W. Scoring Blade Wrench 1
X. Scoring Blade Shims 4
Y. Tool Holder 1
Z. Hex Wrench Set
(1.5, 2, 2.5, 3, 4, 5, 5.5, 6, 8, 10mm) ...1 Ea
AA. Open-End Wrench Set .....(8/9, 10/12, 12/14, 14/17, 17/19, 21/23mm).....1 Ea
AB. Green Touch-Up Paint Can 1
AC. Beige Touch-Up Paint Can 1
AD. Blade Locking Tool 1
AE. Base Feet 4
AF. Foot Studs M14-2.0 x 45 4
AG. Sliding Table Lever 1
AH. Cabinet Keys 2

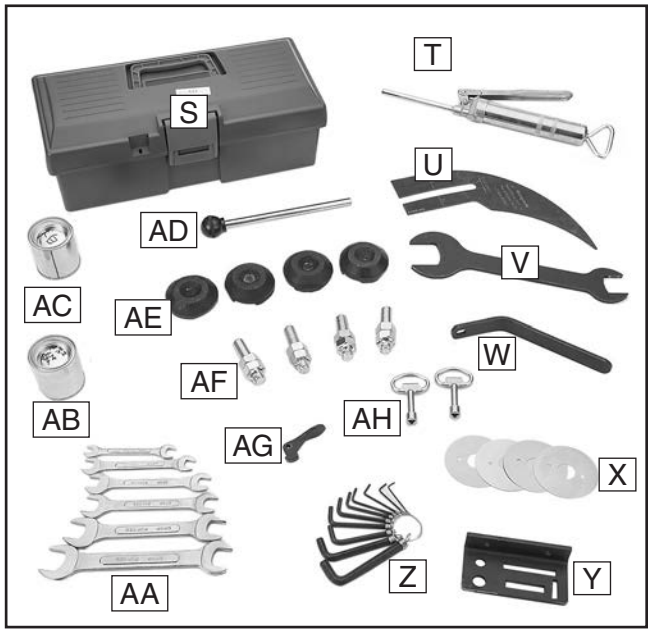


Figure 11. Crate 1 toolbox inventory.

Crate 2 (Figure 12) **Qty**

AI. Crosscut Fence 1
AJ. Sliding Table 1
AK. Miter Fence 1
AL. Rip Fence 1
AM. Short Support Bar 1
AN. Long Support Bar 1
AO. Rip Fence Table Scale Bracket 1
AP. End-Caps 4

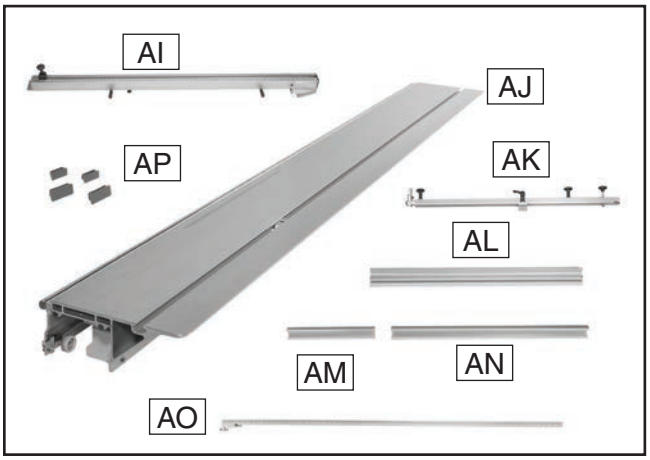


Figure 12. Crate 2 inventory.

Hardware (not shown) **Qty**

Blade Guard Lower Support Arm:
—Hex Bolts M10-1.5 x 25 4
—Lock Washers 10mm 4
—Flat Washers 10mm 4

Blade Guard Upper Support Arm:
—Hex Bolts M10-1.5 x 25 2
—Lock Washers 10mm 2
—Flat Washers 10mm 2

Crosscut Fence:
— Wood End-Cap 1
— Tap Screws #6 x 1" 4
— Flat Washers 4mm 4

Rip Fence Table Scale Bracket:
—Flat Hd. Screws M6-1 x 30 2
—Flat Hd. Screws M6-1 x 35 2
—Flat Washers 6mm 2
—Lock Washers 6mm 2
—Hex Nuts M6-1 2

Saw Base:
—Hex Bolts M16-2 x 70 w/Hex Nuts 4

Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:
- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Figure 13. T23692 Orange Power Degreaser.

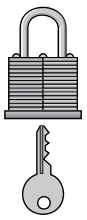
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

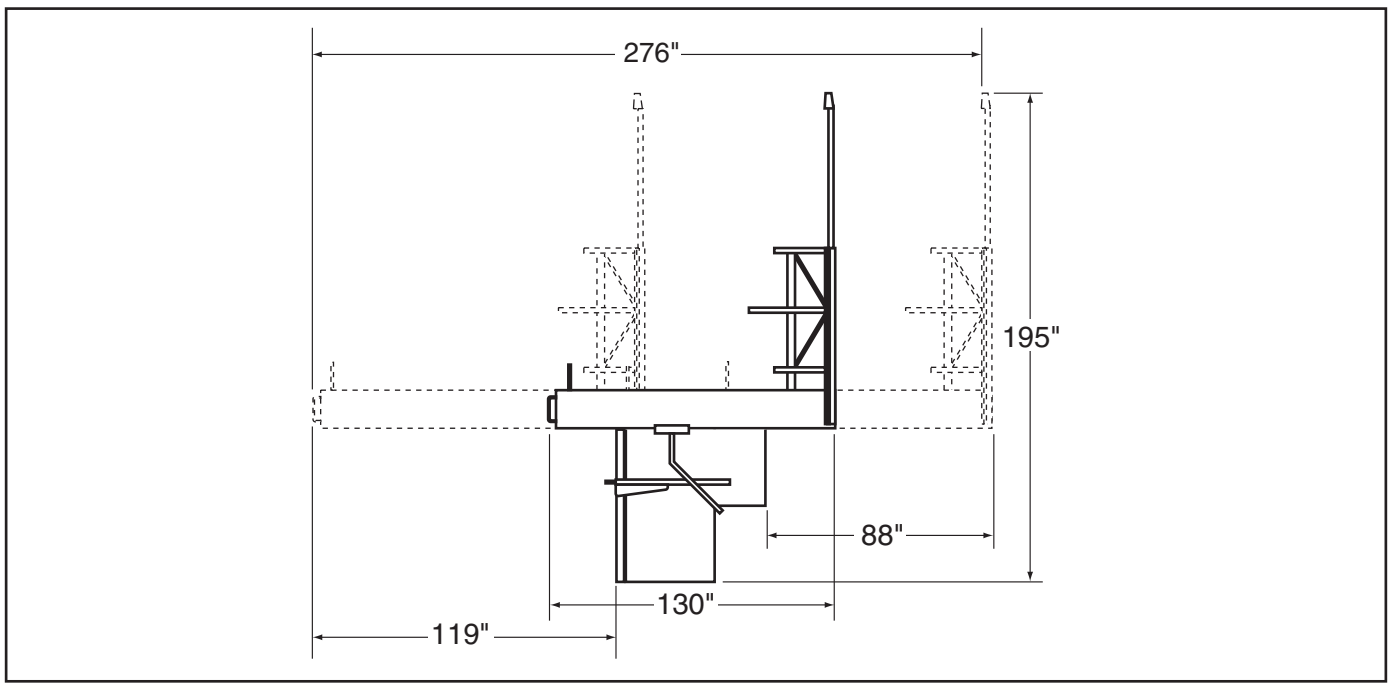
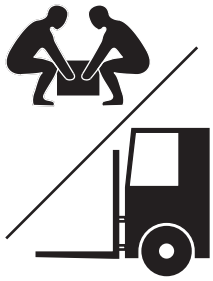


Figure 14. Minimum working clearances.

Lifting & Placing Saw



⚠WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

To lift and place saw:

1. Position crate as close to installation location as possible.

2. Remove top of crate. Position forklift forks as wide as they can be while still fitting under center opening (see **Figure 15**).

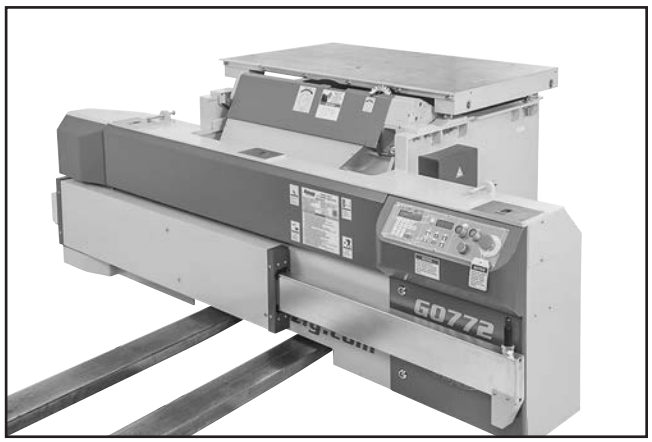


Figure 15. Inserting forks for lifting table saw.

3. Remove small items packed around saw and unbolt saw from pallet.

⚠WARNING

DO NOT lift saw any higher than necessary to clear pallet. Serious personal injury and machine damage may occur if safe moving methods are not followed.

4. With an assistant holding each end to help stabilize load, lift saw with forklift just high enough to clear pallet, and move it to your predetermined location.

5. Place each foot under one of four mounting holes in frame, then thread foot stud into frame roughly half its length (see **Figure 16**), making sure jam nuts are installed on studs.

6. Carefully lower studs onto feet with forklift (see **Figure 16**), and then back forklift away.

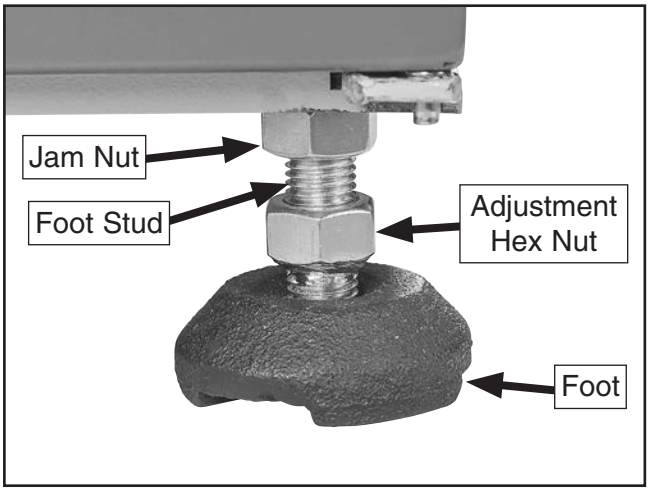


Figure 16. Foot components properly installed in frame and resting on foot.

7. Place level on cast-iron table. Rotate adjustment hex nut (see **Figure 16**) at each foot, to level saw table from left-to-right and from front-to-back. Leveling saw allows sliding table to move smoothly.

8. Tighten jam nuts against frame to prevent feet from moving after leveling.

Assembly

It takes approximately two hours to assemble the saw and make the required adjustments to prepare the saw for the test run.

The sliding table weighs approximately 330 lbs. and is shipped upside down in the crate. It must be lifted and carefully positioned right-side up onto the saw frame during assembly. If you are using a forklift, you'll need to use cardboard or heavy cloth between table and forklift to prevent scratching the aluminum surface.

If a forklift is not available, the sliding table can be lifted into place by four strong people—having one lift from each corner. The only other part of the assembly that requires additional help is installation of the extension tables and blade guard arm.

To assemble sliding table saw:

1. Remove red shipping brace shown in **Figure 17**, then re-install brace fasteners.

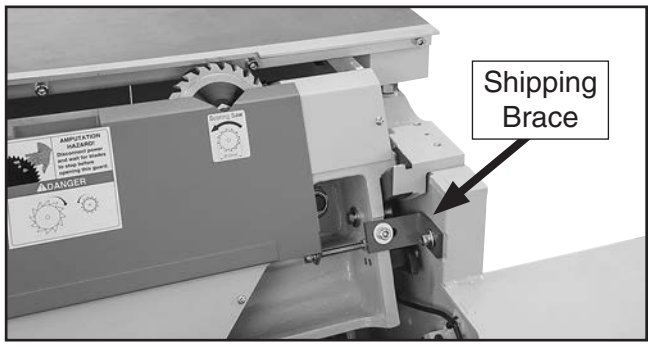


Figure 17. Location of shipping brace that must be removed

2. Remove cover on side of control panel (see **Figure 18**).

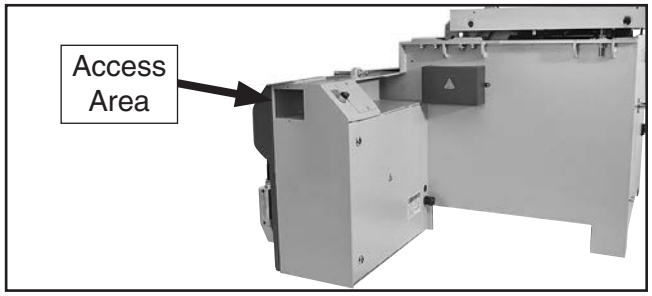


Figure 18. Location of access area.

3. Place crate with sliding table in front of saw, so beveled edge of table is facing away from saw (see **Figure 19**).

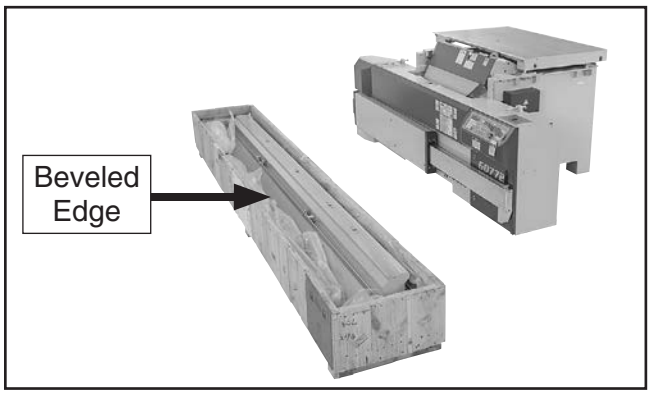


Figure 19. Sliding table crate positioned in front of saw to prepare for installation.

4. Remove sides of crate and plastic bag from around sliding table.

⚠WARNING

Lifting sliding table or other heavy components without proper assistance or equipment may result in strains, back injuries, crushing injuries, or property damage.

5. Place cardboard onto forks, then position sliding table right side up onto forks, so beveled edge faces forward.

6. Lift sliding table just higher than saw (see **Figure 20**), then carefully place table on saw.

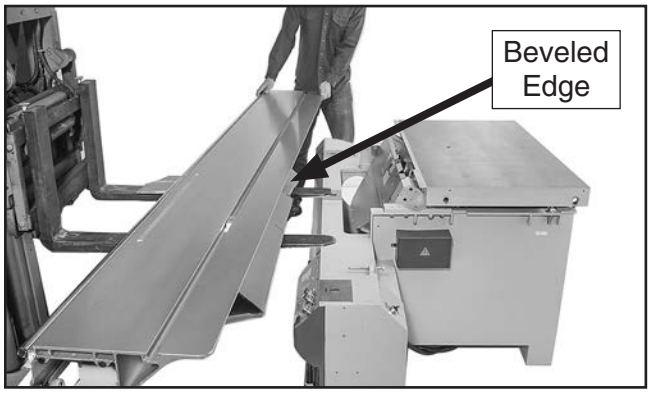


Figure 20. Positioning sliding table onto base.

7. Visually align mounting holes in sliding table base and saw, then install (2) M14-2 x 45 hex bolts with (2) 14mm lock washers and (2) 14mm flat washers through into ends of table base (see **Figure 21**). Finger tighten only, for now.

8. Push sliding table against parallelism adjustment bolts (see **Figure 21**), then final tighten hex bolts from last step. The parallelism bolts are preset at the factory and should not require any adjustment.

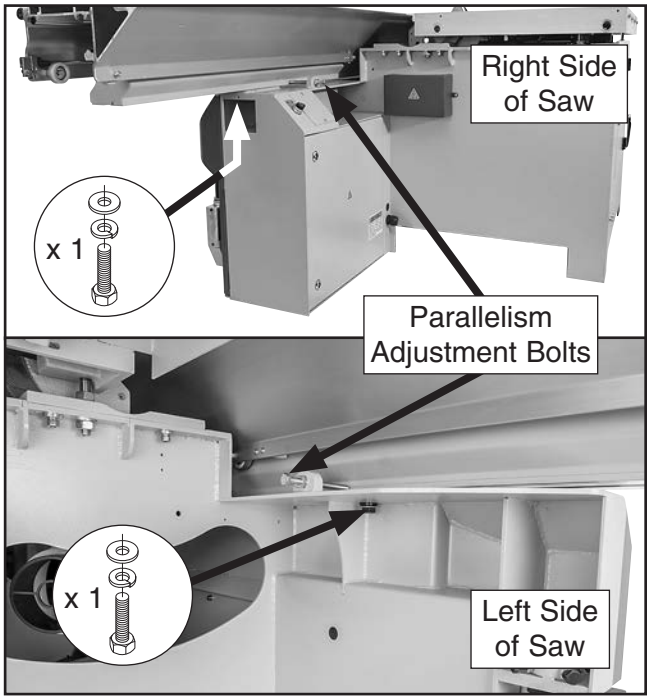


Figure 21. Location to install hex bolts in sliding table base and saw.

9. Install sliding table lever using (1) pre-installed M6-1 x 20 button head cap screw and (1) M6-1 hex nut (see **Figure 22**).

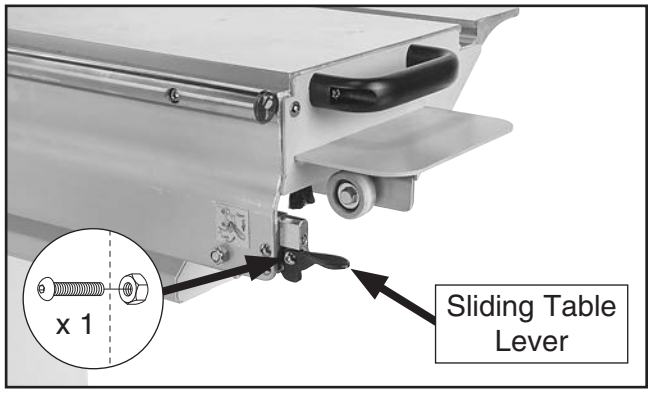


Figure 22. Sliding table lever installed.

10. Move sliding table lever down to unlock sliding table. Move table right to access center mounting hole, located near saw blade.

11. Install (1) M14-2 x 45 hex bolt with (1) 14mm lock washer and (1) 14mm flat washer through saw into center of table base (see **Figure 23**). Finger tighten only, for now.

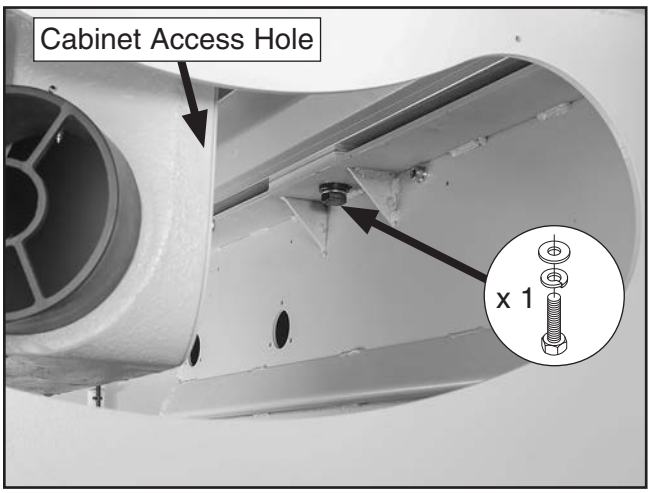


Figure 23. Center bolt installed to secure sliding table base to saw.

12. Re-install cover removed in **Step 2**.

13. Install end handle with (2) pre-installed M5-.8 x 12 button head cap screws and (2) 5mm flat washers (see **Figure 24**).

14. Finish securing end handle with (2) M6-1 x 15 cap screws, (2) 6mm conical lock washers, and (2) 6mm flat washers (see **Figure 24**).

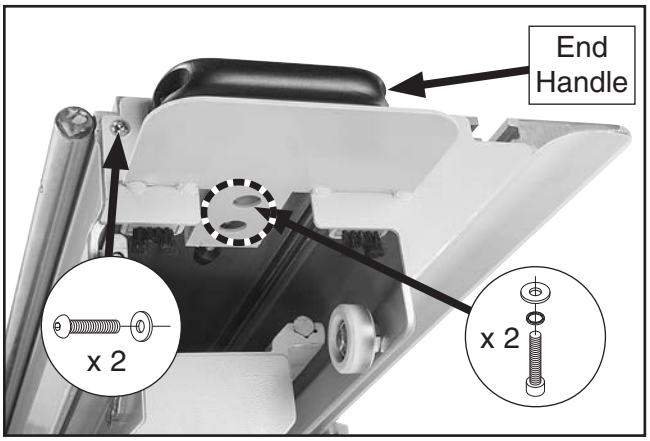


Figure 24. End handle installed on front (right) side of sliding table.

15. Install end plate onto rear (left) end of sliding table with (2) pre-installed M5-.8 x 12 button head cap screws and (2) 5mm flat washers (see **Figure 25**). Finish by installing (2) M6-1 x 15 cap screws, (2) 6mm conical lock washers, and (2) 6mm flat washers.

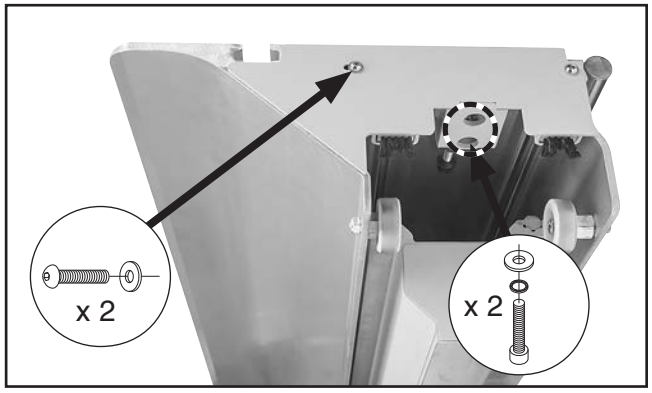


Figure 25. End plate installed on rear (left) end of sliding table.

16. Install small extension table with (3) pre-installed M8-1.25 x 20 hex bolts and (3) 8mm flat washers, as shown in **Figure 26**. Finger tighten only, for now.

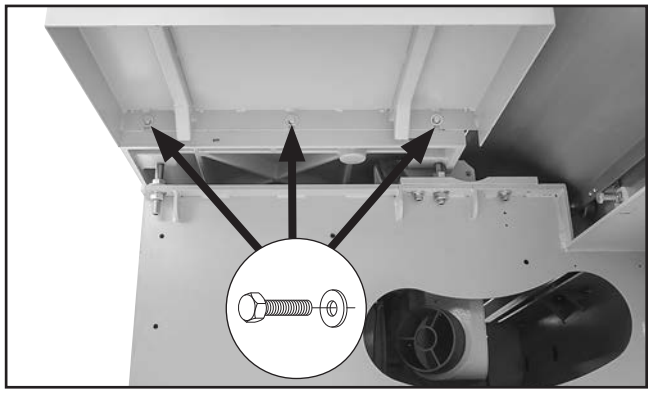


Figure 26. Underside view of small extension table attached to cast iron table.

17. Place straightedge across cast iron table and small extension table. Loosen hex bolts shown in **Figure 27** and adjust small extension table as necessary to level it flush with cast iron table. Final tighten hex bolts with wrench.

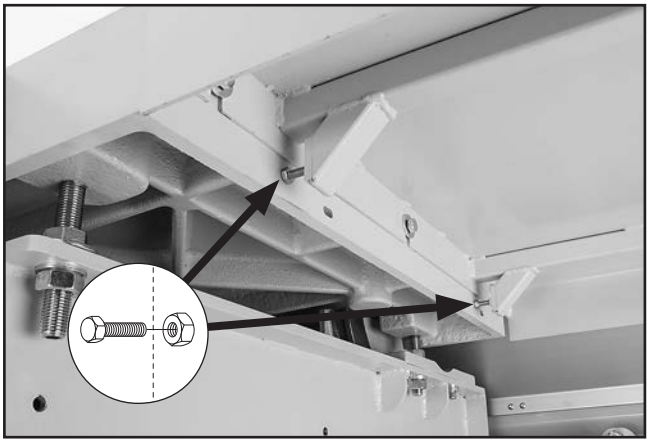


Figure 27. Location of hex bolts used to level small extension table.

18. Install large extension table with (4) pre-installed M8-1.25 x 20 hex bolts and (4) 8mm flat washers (see **Figure 28**). Use straightedge to verify extension table and cast iron table are flush, then tighten bolts.

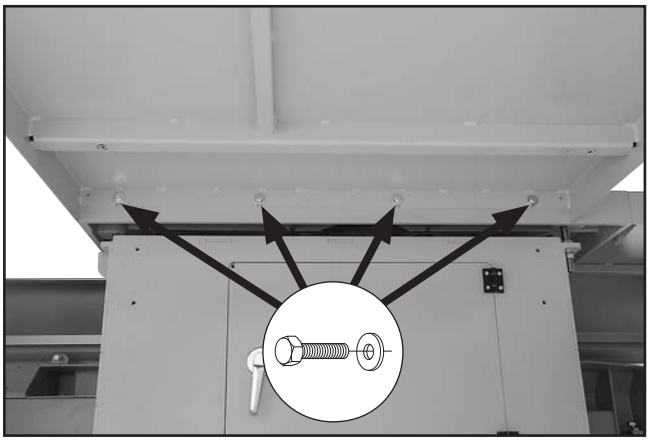


Figure 28. Underside view of large extension table attached to cast iron table.

19. Install extension table supports onto cabinet with (4) pre-installed M8-1.25 x 20 hex bolts and (4) flat washers, as shown in **Figure 29**. Finger-tighten only, for now.

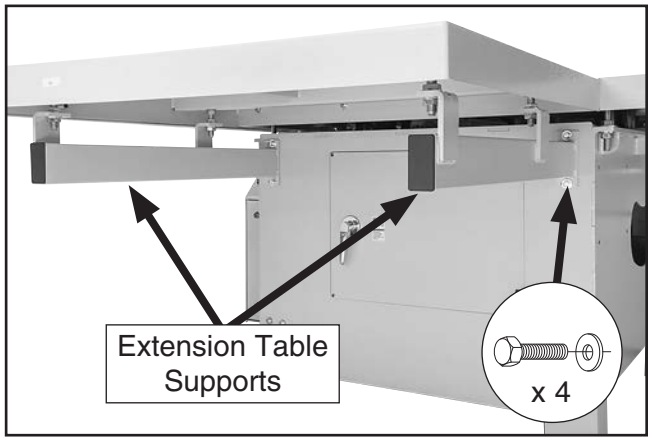


Figure 29. Extension table supports installed.

20. Secure each extension table support to large extension table with two studs. Thread included hex bolt through each stud (see **Figure 30**) into extension table.

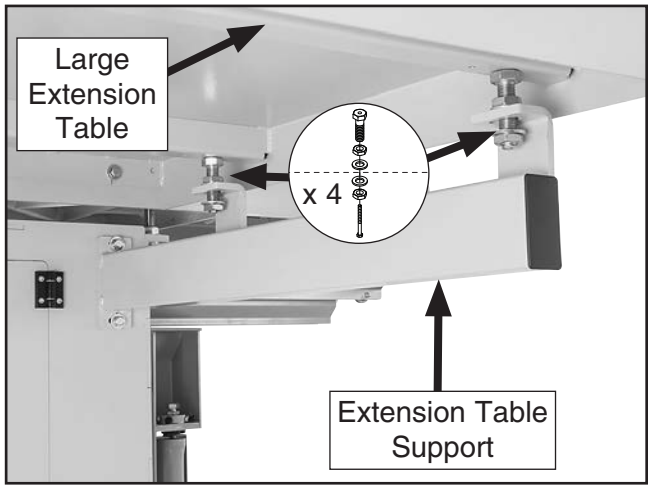


Figure 30. Table support secured to extension table with studs.

21. Tighten hex bolts that secure supports to cabinet.

22. Place straightedge across cast iron table and adjust hex nuts on studs (see **Figure 31**) to align top of large extension table with top of cast iron table.

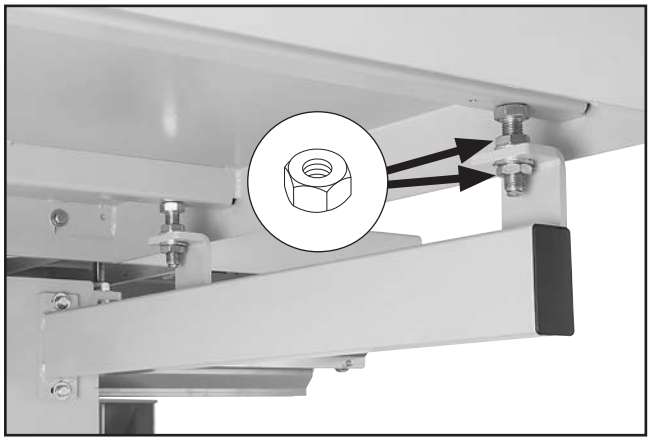


Figure 31. Hex nuts used to align large extension table with cast iron table.

23. Attach lower support arm to saw cabinet with (4) M10-1.5 x 25 hex bolts, (4) 10mm lock washers, and (4) 10mm flat washers.

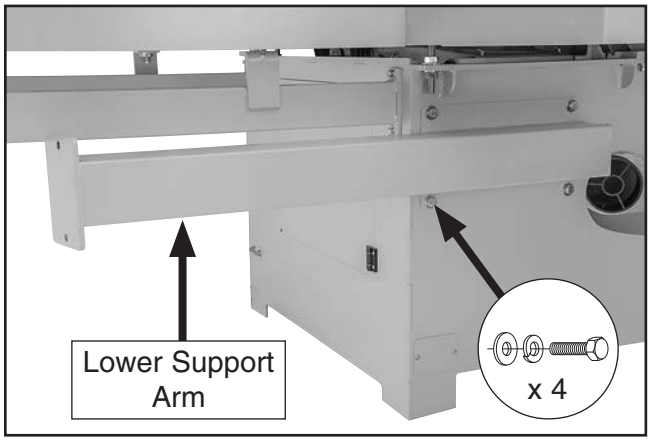


Figure 32. Blade guard lower support arm attached to saw cabinet.

24. Attach upper support arm to lower support arm with (2) M10-1.5 x 25 hex bolts, (2) 10mm lock washers, and (2) 10mm flat washers, as shown in **Figure 33**.

25. Remove (4) pre-installed M8-1.25 x 20 cap screws and (4) 8mm lock washers from end of upper support arm (see **Figure 33**).

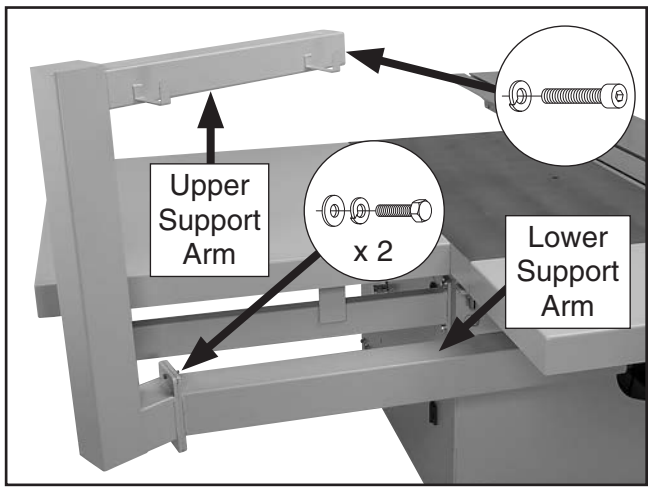


Figure 33. Upper support arm connected to lower support arm.

26. Secure swing arm to upper support arm with four cap screws and lock washers removed in previous step, as shown in **Figure 34**.

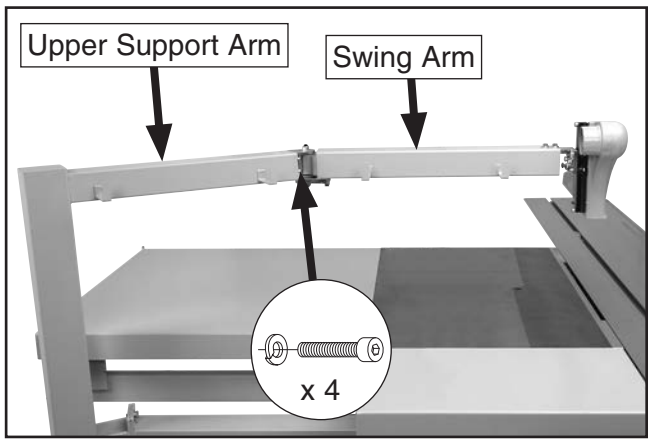


Figure 34. Swing arm mounted to upper support arm.

27. Push slide lock on blade guard housing to OPEN, then slide on flat blade guard, as shown in **Figure 35**.

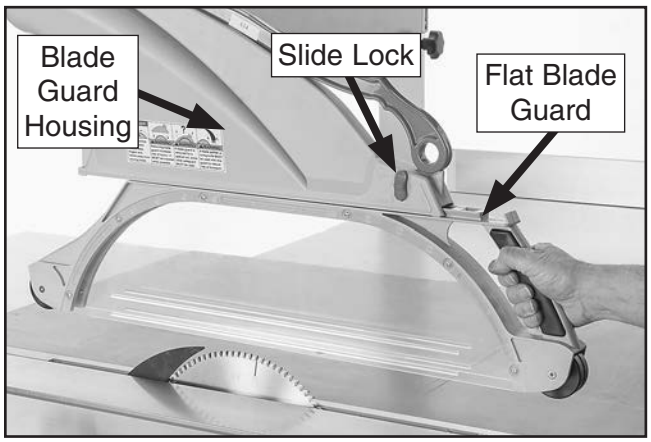


Figure 35. Installing flat blade guard onto guard housing.

28. Adjust cap screws installed in **Step 26** to make bottom of blade guard parallel with cast iron table, tighten cap screws, then secure lock knob shown in **Figure 36**.

29. Adjust cap screws, lock nuts, and hex bolts on swing arm (see **Figure 36**) to position blade guard parallel with blade slot, then tighten all fasteners.

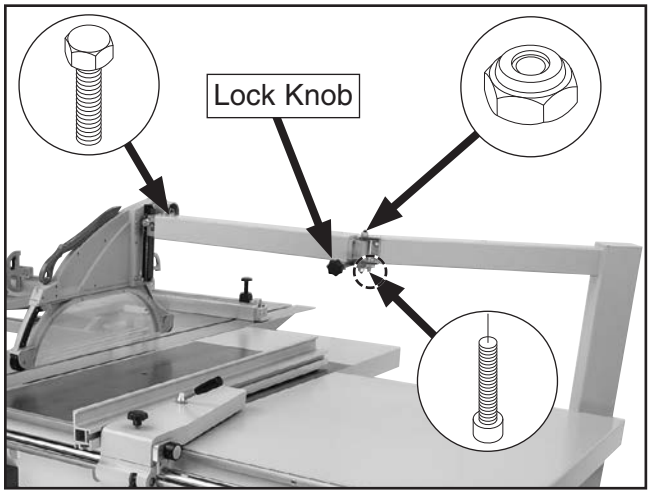


Figure 36. Location of components for adjusting blade guard to blade slot.

30. Position crosscut swing arm so it is perpendicular to sliding table (see **Figure 37**).

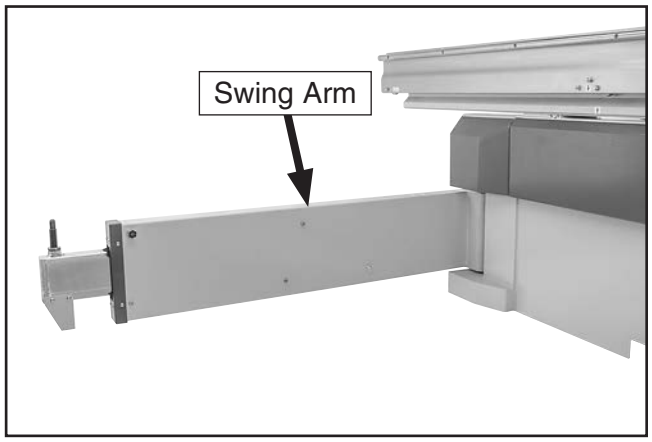


Figure 37. Crosscut swing arm perpendicular to table.

31. With assistance from other people, place crosscut table on swing arm pivot pin, and slide crosscut table onto sliding table rail, as shown in **Figure 38**.

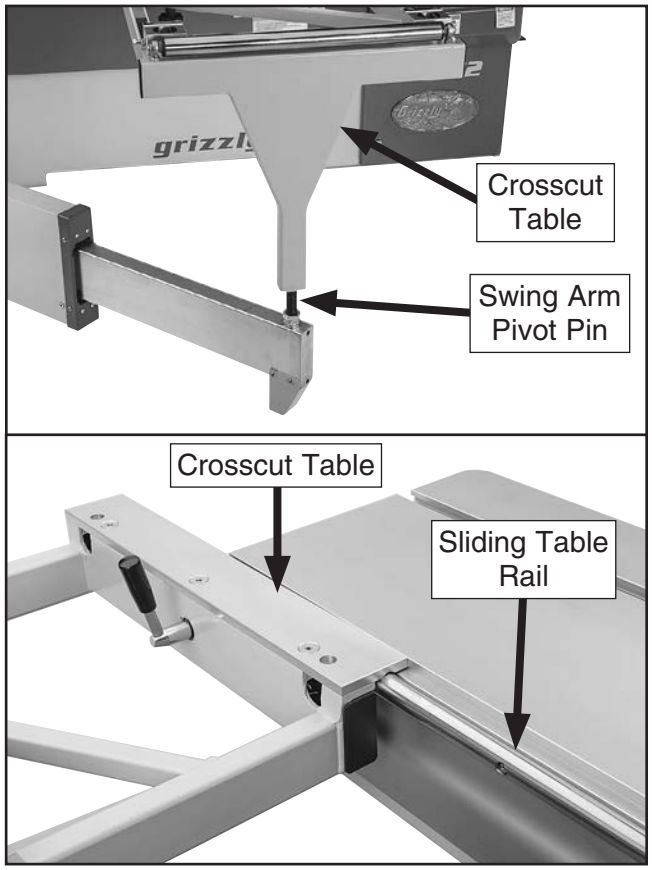


Figure 38. Attaching crosscut table to sliding table rail and swing arm pivot pin.

32. Loosen lock knob (see **Figure 39**) to loosen cross support hold-down, slide long crosscut table support bar onto hold-down, then tighten lock knob and install end caps.

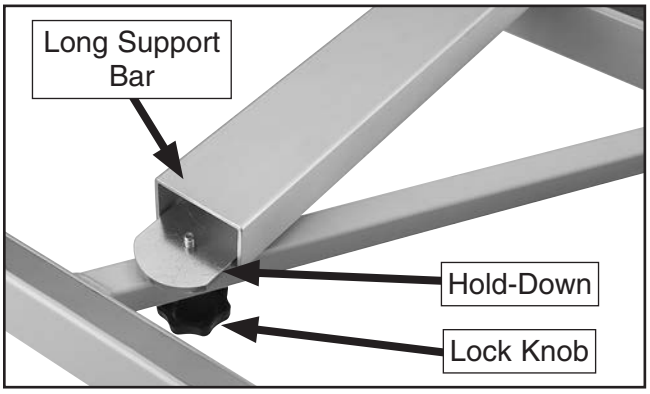


Figure 39. Crosscut support bar components.

33. Loosen pre-installed hex bolts on crosscut table. Slide small support bar onto hold-downs (see **Figure 40**), tighten both hex bolts, then install end caps.

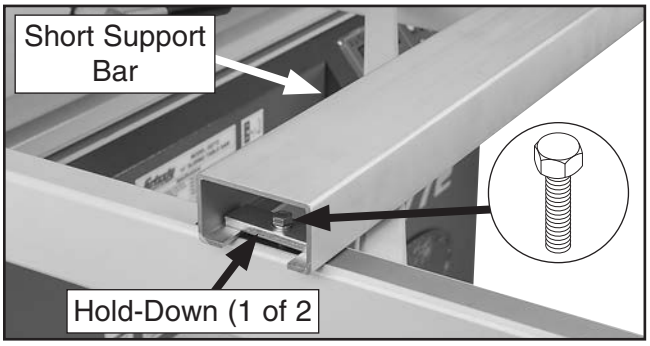


Figure 40. Short crosscut support bar installed.

34. Unlock crosscut fence lock handles (see **Figure 41**), insert guide pins on bottom of crosscut fence into front or rear crosscut table holes, then tighten lock handles.

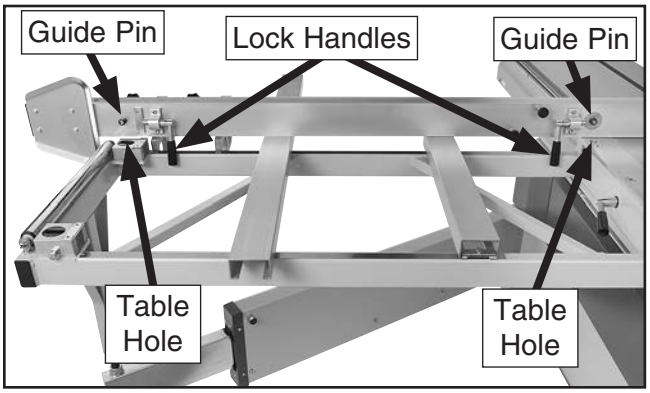


Figure 41. Mounting crosscut fence to crosscut table in front table holes.

35. Install both flip stops on crosscut fence by unlocking extension piece lock knob, sliding extension piece out, sliding clamp bar on bottom of flip stops into fence (see **Figure 42**), then tightening lock knob.

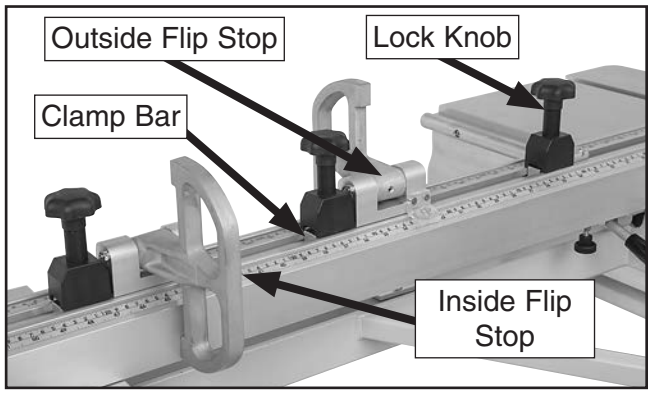


Figure 42. Flip stops installed on crosscut fence.

36. Install wood end-cap onto crosscut fence with (4) #6 x 1" tap screws and (4) 4mm flat washers, as shown in **Figure 43**.

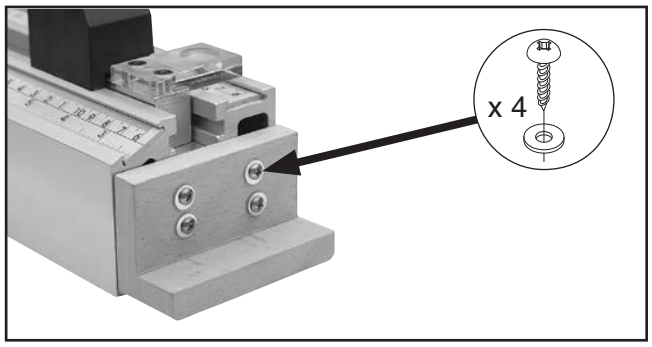


Figure 43. Wood end-cap installed on crosscut fence.

37. Place miter fence bracket (see **Figure 44**) onto sliding table rail. Slide miter fence along sliding table rail and thread pivot knob into block (see **Figure 44**).

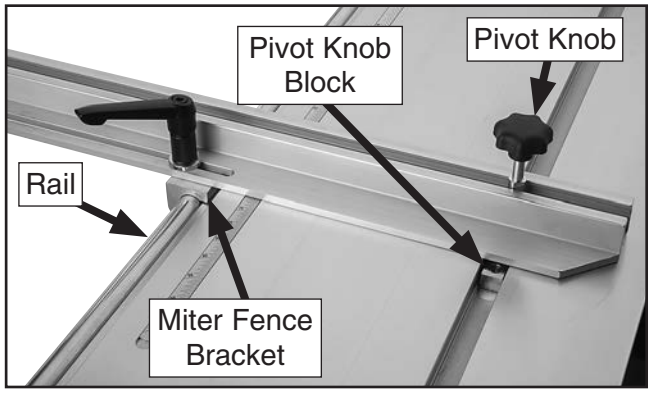


Figure 44. Miter fence installed on sliding table.

38. Install push handle on sliding table by loosening lock knob on push handle, installing handle onto right end of sliding table rail, then tightening knob (see **Figure 45**).

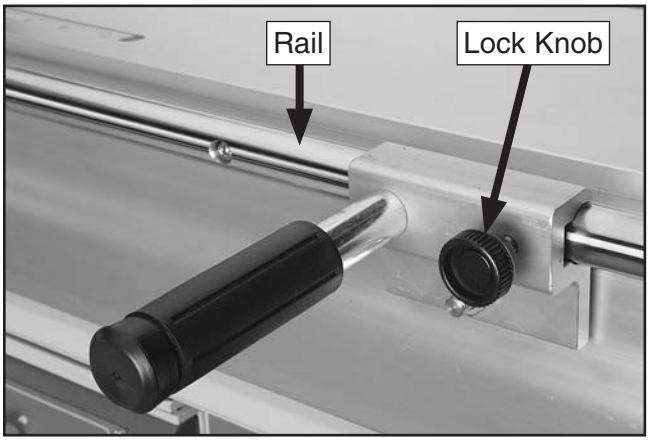


Figure 45. Push handle installed on sliding table rail.

39. Install tool holder on right side of saw cabinet, as shown in **Figure 46**, with included M6-1 x 12 button head cap screws.

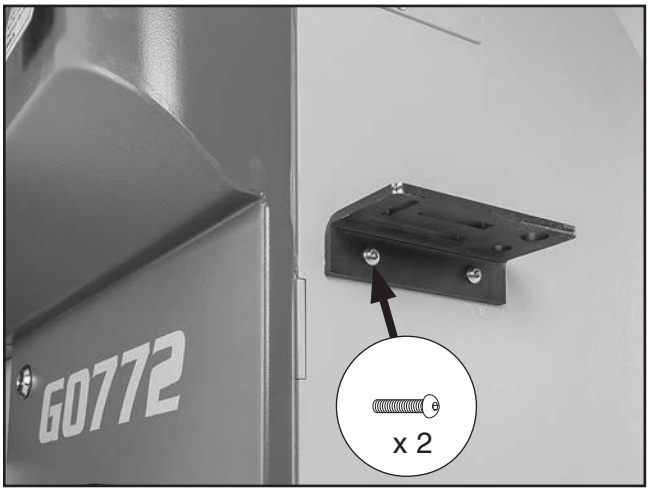


Figure 46. Tool holder installed on saw cabinet.

40. Connect saw to power (refer to **Power Connection** on **Page 37**).

41. Perform **Test Run** procedure (refer to **Page 38**).

42. Set blade to 0° using control panel (see **Figure 3** on **Page 5**), and then raise blade all the way up.

43. DISCONNECT MACHINE FROM POWER!

44. The rip fence rail is pre-assembled with three rail studs and accompanying hardware. Remove (1) hex nut and (1) flat washer from end of each stud, as shown in **Figure 47**.

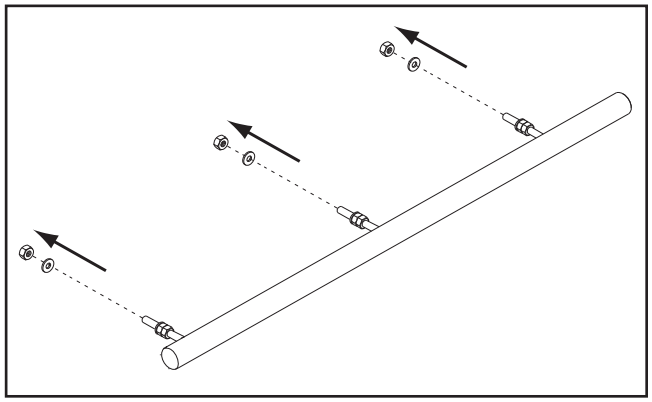


Figure 47. Removing rip fence rail hardware to prepare for installation.

45. Adjust jam nuts, hex nuts, and flat washers on two outer studs so flat washers are 2½" from rail (see **Figure 48**). Adjust fasteners on center stud so flat washer is 2" from rail.

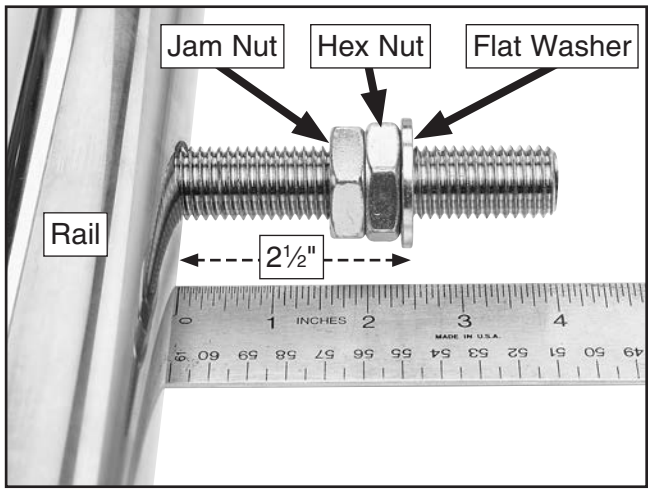


Figure 48. Flat washer on outer stud adjusted correct distance from rail.

46. Insert studs into tables as shown in **Figure 49**, then re-install hardware removed in **Step 44** on *outer* studs and tighten. Position end stop pointing up.

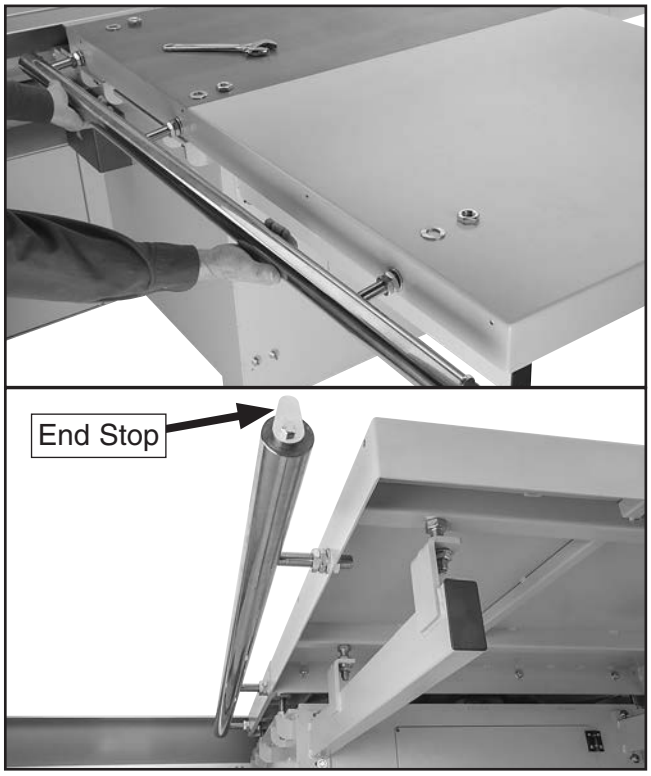


Figure 49. Installing rip fence rail.

47. Slide rip fence base onto rip fence rail. Adjust cams to highest position (see **Figure 50**).

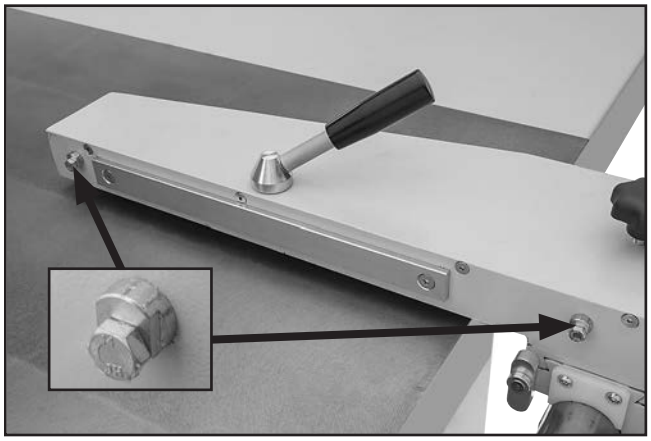


Figure 50. Rip fence cams adjusted to highest positions.

48. Unlock slide lock handle (see **Figure 51**). Carefully slide rip fence rail onto clamping plate. Gap between bottom of rip fence and table should be even from front to back.

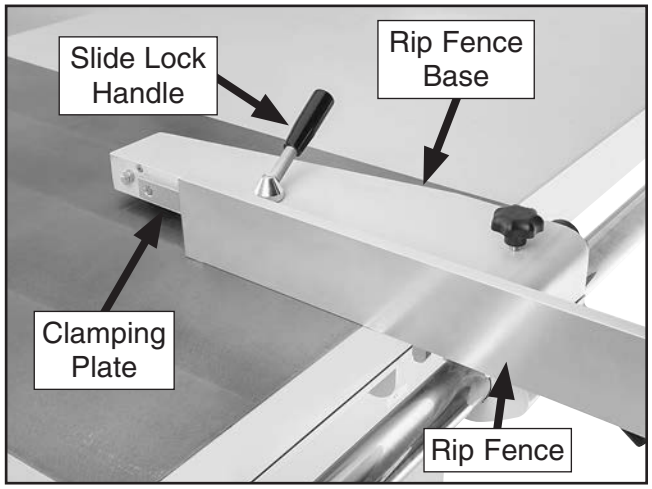


Figure 51. Installing rip fence.

—If gap is not even from front to back, or if fence contacts table, lift rip fence base off of table. Loosen lock nut (see **Figure 52**) and adjust cam nut to raise or lower fence height above table.

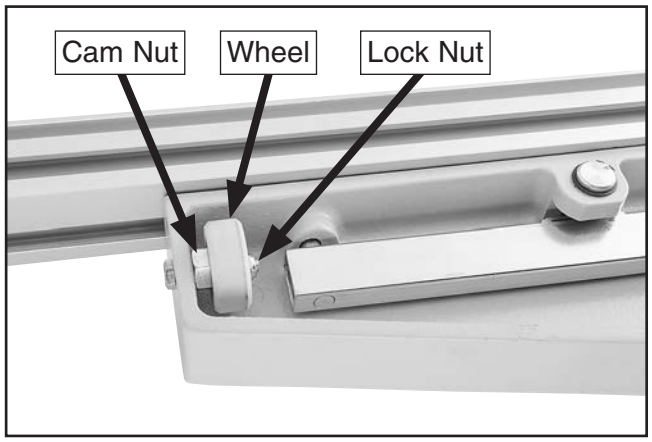


Figure 52. Rip fence height adjustment wheel.

49. Place fence back on table and re-check gap. Repeat adjustments from previous step as necessary, then tighten lock nut on wheel and secure rip fence with slide lock handle.

50. Slide rip fence until it almost touches blade teeth, then lock fence position.

51. Use a feeler gauge (see **Figure 53**) to verify gap between teeth and rip fence at front and back end of blade are the same.

—If gap *is not* the same, adjust jam nuts and hex nuts on stud at right end of rail until gap is even.

Figure 53. Using feeler gauge to verify fence is even from front to back.

52. Move rip fence out of the way.

53. Turn outer hex nut on center stud until flat washer just contacts front of table, as shown in **Figure 54**.

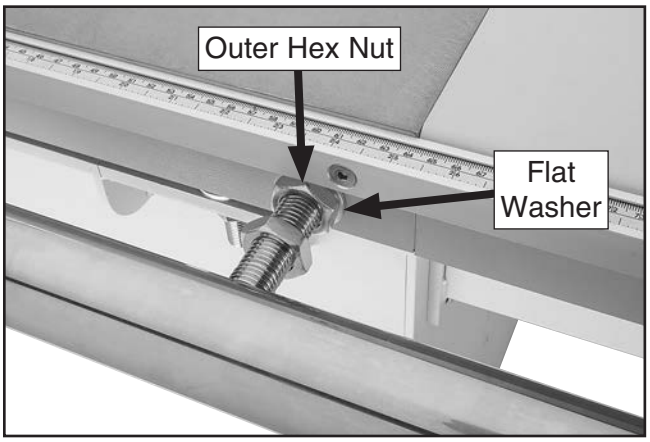


Figure 54. Outer hex nut and flat washer positioned on center rail stud.

54. Install inner hex nut on *center* stud under table, then tighten hex nut until flat washer just contacts table. Further tighten inner and outer hex nuts on center stud with provided wrench to avoid distorting rail.

55. Tighten each jam nut on all three rail studs (see **Figure 55**) to secure rail position against tables.

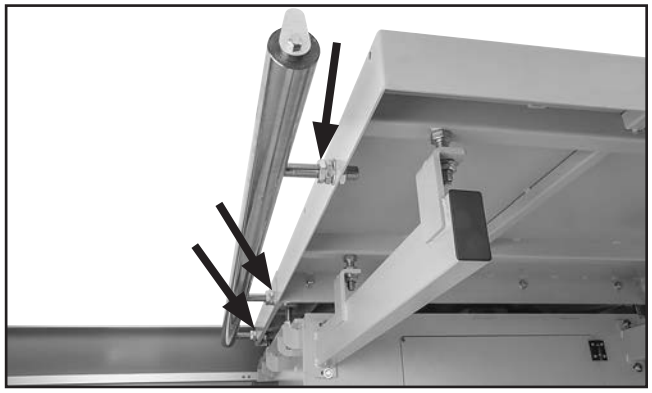


Figure 55. Location of rail stud jam nuts used to secure rail position.

56. Lift rip fence base up and out of the way, then install rip fence scale onto cast iron table with (2) M6-1 x 30 flat head cap screws (see **Figure 56**).

57. Install rip fence scale onto large extension table with (2) M6-1 x 35 flat head cap screws, (2) 6mm flat washers, (2) 6mm lock washers, and (2) M6-1 hex nuts (see **Figure 56**).

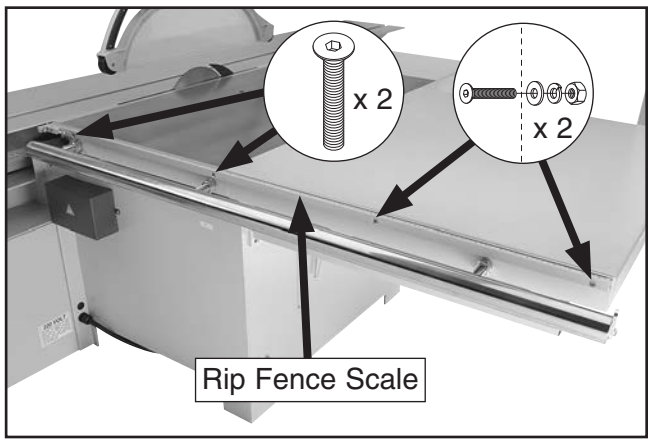


Figure 56. Rip fence scale installed.

58. Place rip fence base back on rail.

59. Move sliding table all the way to the right. Pull blade cover (see **Figure 57**) toward you to open it. It is held closed with magnets and just requires a firm tug to open.

60. Install riving knife (see **Figure 57**). Refer to **Riving Knife** beginning on **Page 44** for detailed information.

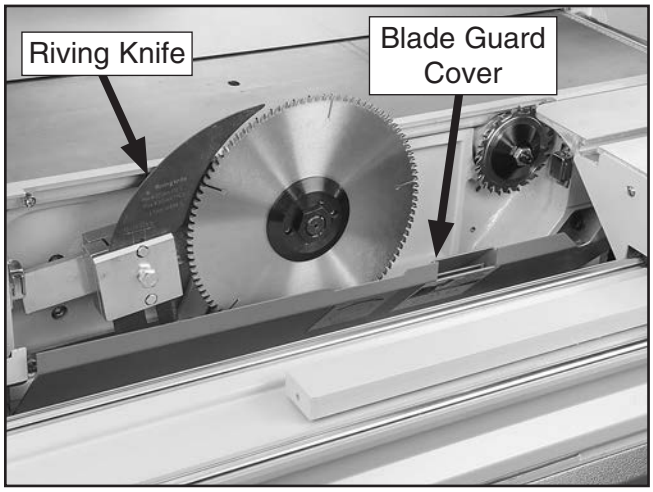


Figure 57. Riving knife installed.

Dust Collection

⚠CAUTION

This machine creates substantial amounts of dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust collection system.

Minimum CFM at 5" Dust Port:	**615 CFM**
Minimum CFM at 3" Dust Port:	**150 CFM**

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect dust collection hoses:

1. Fit 5" dust hose over dust port on rear side of cabinet, as shown in **Figure 58**, and secure with hose clamp.

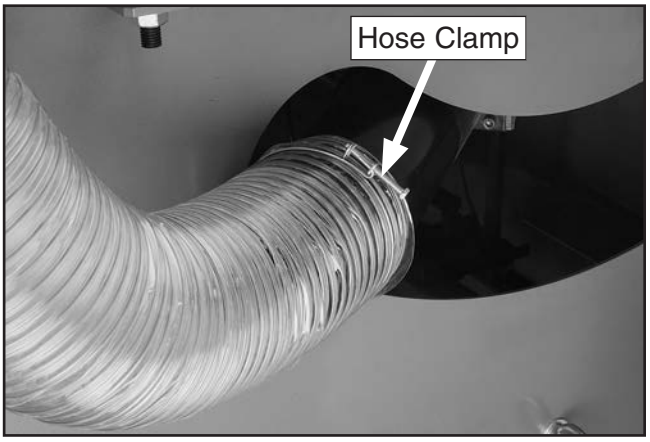


Figure 58. 5" dust hose attached to dust port.

2. Fit 3" dust hose over dust port on blade guard, as shown in **Figure 59**, then secure it with a hose clamp.

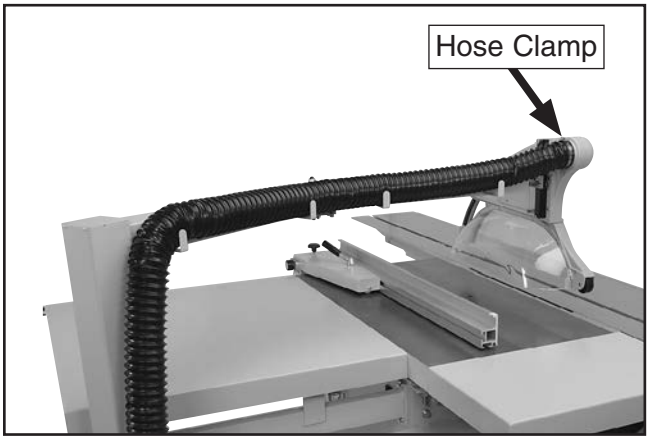


Figure 59. 3" dust hose attached to blade guard.

3. Connect 5" and 3" dust hoses to a Y-fitting, as shown in the example in **Figure 60**, then attach it to a single dust collection branch line.

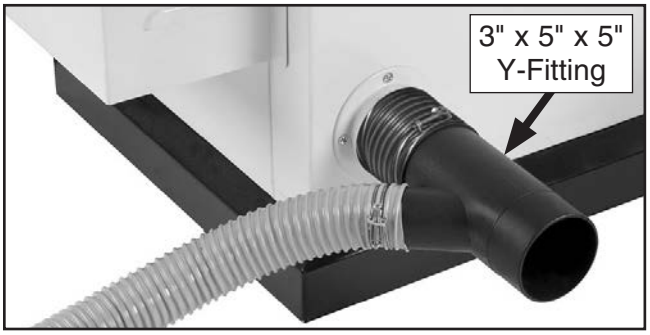
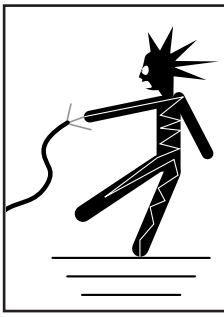


Figure 60. Example of dust hoses connected with Y-fitting.

4. Tug on dust hoses to make sure they do not come off. A tight fit is necessary for proper performance.

Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.



⚠WARNING

Electrocution, fire, or equipment damage may occur if machine is not correctly grounded and connected to the power supply.

Note About Phase Converters: Avoid using a static phase converter to supply 3-Phase power for this machine, as it could damage or decrease the life of sensitive electrical components. If you must use a phase converter, only use a rotary phase converter that is sized at least 50% larger than the largest HP rating of this machine. If using a phase converter to supply power, only connect the manufactured leg or "wild wire" to the "S" terminal (see location on **Page 87**). The S terminal can handle power fluctuations because it is wired directly to the motor.

To connect saw to power:

1. Open electrical panel door (see **Figure 63**) with included key.

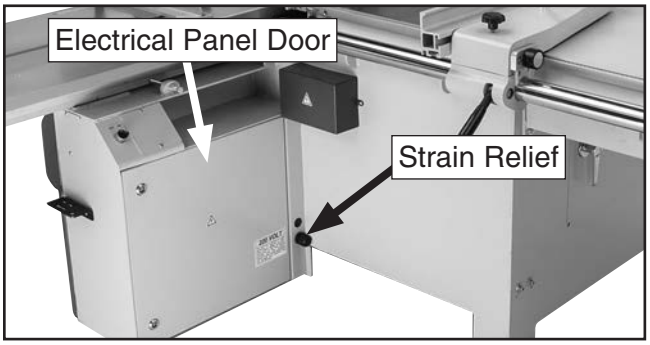


Figure 63. Location of electrical panel and strain relief.

2. Insert incoming power wires where strain relief is located on cabinet next to electrical panel door.

⚠WARNING

During next step, make sure incoming ground wire is connected to left-most terminal post in the power junction box so machine is properly grounded. An ungrounded or improperly grounded machine may have an electrified frame which could cause electrocution when touched.

3. Connect ground wire to ground terminal, then connect incoming power wires to bottom R, S, T terminals shown in **Figure 64**.

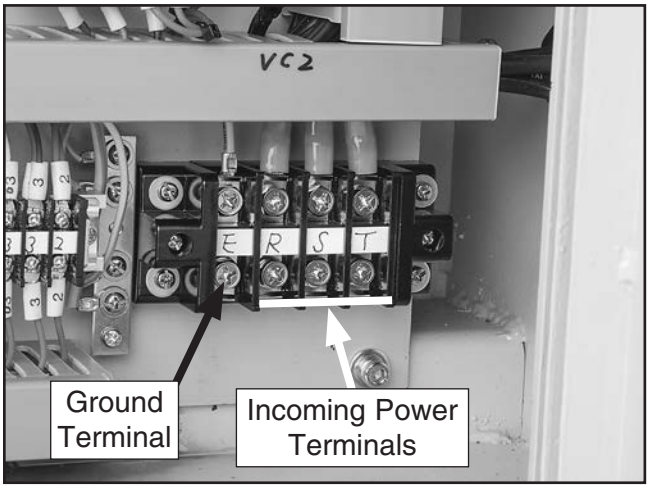


Figure 64. Terminal locations to connect incoming power wires and ground wire.

4. Make sure wires have enough slack so they are not pulled tight or stretched.

5. Close and secure electrical panel door, then perform **Test Run**.

Connecting to Power Source

Move the disconnect switch handle to the ON position, as illustrated below. The machine is now connected to the power source.

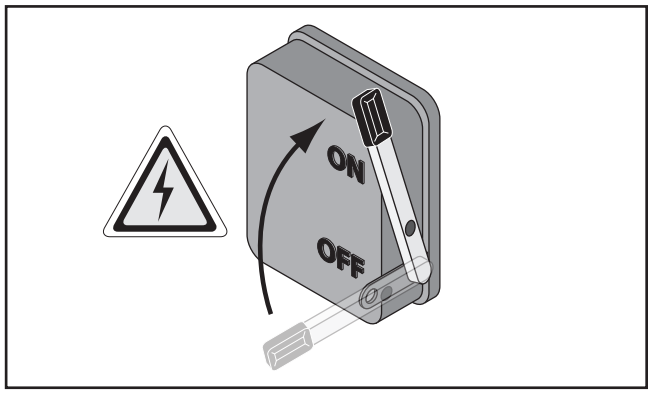


Figure 61. Connecting power to machine.

Disconnecting from Power Source

Move the disconnect switch handle to the OFF position, as illustrated below. The machine is now disconnected from the power source.

Note: *Lock the switch in the OFF position to restrict others from starting the machine.*

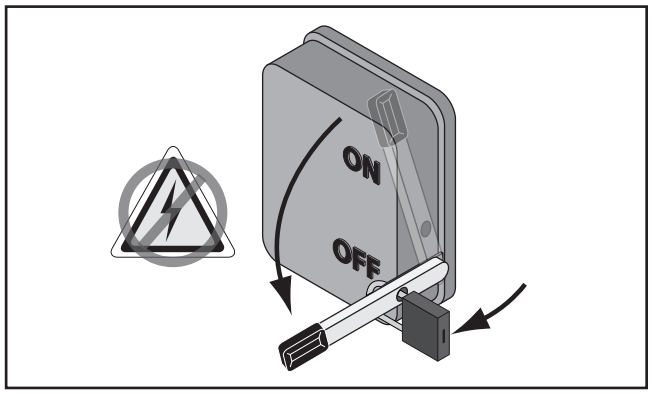


Figure 62. Disconnecting power from machine.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning properly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The test run consists of verifying the following: 1) The motors power up and run correctly, 2) the safety features of the Emergency Stop button and blade cover switch work correctly, and 3) the main blade turns forward (clockwise when viewed from front of saw) and the scoring blade turns opposite the main blade.

⚠WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Make sure you understand all safety instructions at the beginning of manual and that machine is set up properly.

2. Make sure all tools and objects used during setup are cleared away from machine.

3. Make sure saw blades are installed tightly and blade guard cover is closed.

4. Connect saw to power.

5. Turn main power switch ON (see **Figure 65**).

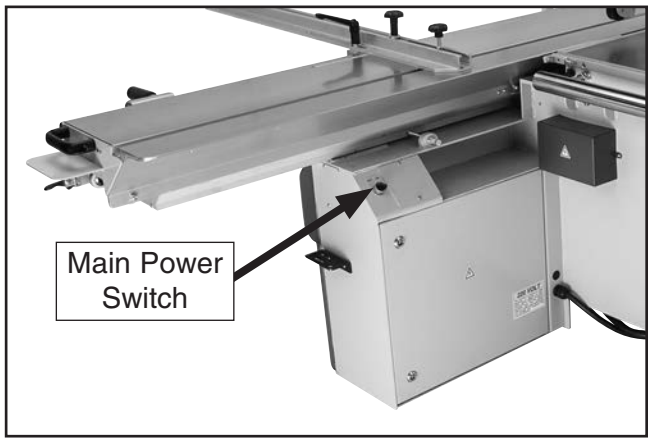


Figure 65. Main power switch location.

6. Push Emergency Stop button (see **Figure 66**), then twist it clockwise so it pops out. When button pops out, switch is reset and will allow operation.

Figure 66. Location of Emergency Stop button on control panel.

7. Verify saw is operating correctly by pushing main blade ON button (refer to **Figure 3** on **Page 5**). Wait 5–10 seconds until you hear a faint "click", then press scoring blade ON button.

   —When operating correctly, machine runs smoothly with little or no vibration or rubbing noises.

   —Investigate and correct strange or unusual noises or vibrations before operating machine further. Always stop machine and disconnect it from power before investigating or correcting potential problems.

8. Verify main blade is rotating clockwise (when standing in front of machine) and scoring blade is rotating counterclockwise (opposite direction as main blade).

   Note: *You may need to stop the blade rotation and watch them come to a stop to determine which direction they are rotating.*

   —If blades are rotating in wrong direction, stop machine and DISCONNECT FROM POWER! Phase of incoming power supply is reversed. Open electrical panel door, swap wires at “R” and “T" terminals (see **Figure 67**), then close panel and reconnect machine to power.

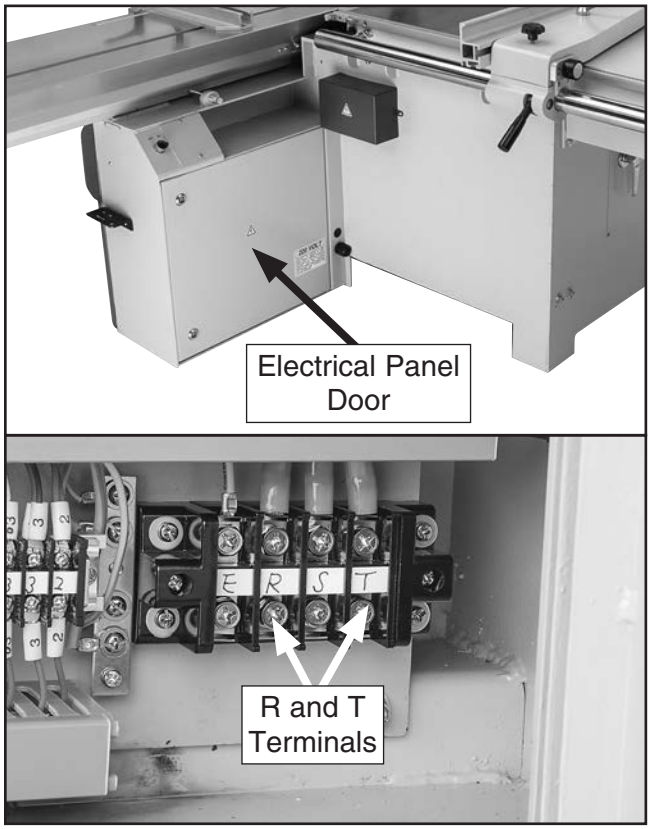


Figure 67. Up-close view of power supply terminals inside electrical panel.

9. Press Emergency Stop button on front of machine to turn machine ***OFF***.

10. WITHOUT resetting Emergency Stop button, press each ON button. Machine should *not* start.

—If machine *does* start (with Emergency Stop button pushed in), immediately disconnect power to machine. Emergency Stop button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

11. Move sliding table all the way right, then open blade cover, as shown in **Figure 68**. This activates blade cover safety switch to prevent saw from starting while cover is open.

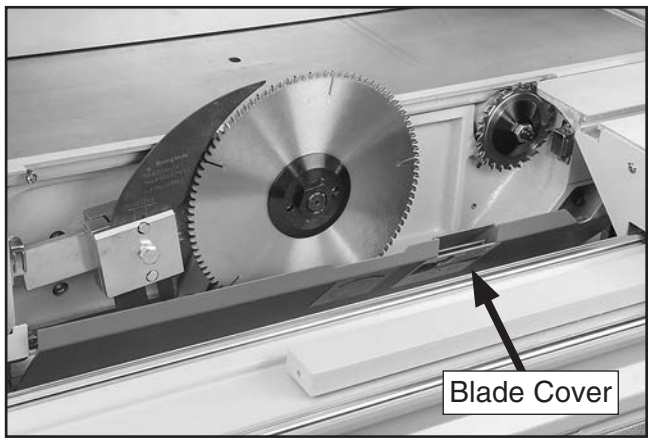


Figure 68. Blade cover open.

12. While staying safely away from blade, reset Emergency Stop button, then try to start main blade and then scoring blade.

—If blades *do not* start, blade cover safety switch safety feature is working correctly.

—If blades *do* start (with blade cover open), immediately turn machine ***OFF*** and disconnect power. The blade cover safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

13. Push Emergency Stop button, carefully close blade cover, then move sliding table back to center of machine.

Congratulations. **Test Run** is complete!

Recommended Adjustments

The following list of adjustments were performed at the factory before the machine was shipped:

- Aligning Scoring Blade .....**Page 52**
- Blade Tilt Calibration ..... **Page 80**
- Sliding Table Parallel Adjustment....**Page 82**
- Squaring Crosscut Fence to Blade **Page 84**
- Calibrating Rip Fence..... **Page 83**

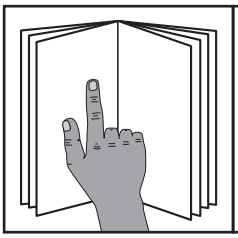
Be aware that pre-adjusted machine components can shift during shipping. Pay careful attention to these adjustments during operation of the machine. If you find that the adjustments are not set according to the procedures in this manual or your personal preferences, re-adjust them.

SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

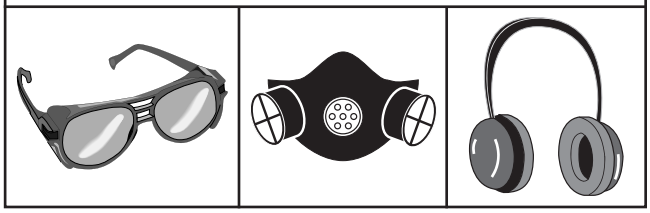


⚠WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

⚠WARNING

Damage to your eyes, lungs, and hearing could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



To complete a typical operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts blade tilt, if necessary, to correct angle of desired cut.
3. Adjusts blade height approximately ¼" higher than thickness of workpiece.
4. Adjusts fence to desired width of cut, then locks it in place.
5. Adjusts blade guard for workpiece height.
6. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through the blade without interference.
7. Puts on safety glasses, respirator, and hearing protection. Locates push sticks, if needed.
8. Feeds workpiece all the way through blade while maintaining firm pressure on workpiece against table and fence.
9. Turns machine ***OFF*** immediately after cut is complete and waits for blades to completely stop before removing workpiece.

NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Workpiece Inspection

Some workpieces are not safe to cut on this machine or may need to be modified before they can be safely cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the motor bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw greatly increases the risk of injury and damage to the saw or blade.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.

- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and may move unpredictably when being cut.

- ***Minor Warping:*** Slightly cupped workpieces can be safely supported with cupped side facing the table or fence; however, workpieces supported on the bowed side will rock during the cut, which could cause kickback.

Through & Non-Through Cuts

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through, as shown in the **Figure** below. Examples of through cuts are rip cuts, cross cuts, miter cuts, and beveled cuts. The blade guard assembly MUST be used when performing through cuts.

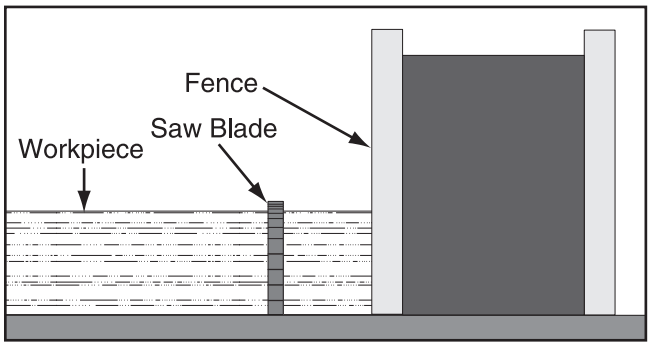


Figure 69. Example of a through cut (blade guard not shown for illustrative clarity).

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in the **Figure** below. The blade guard assembly MUST be used when performing all non-through cuts, except when the guard will not safely accommodate the workpiece.

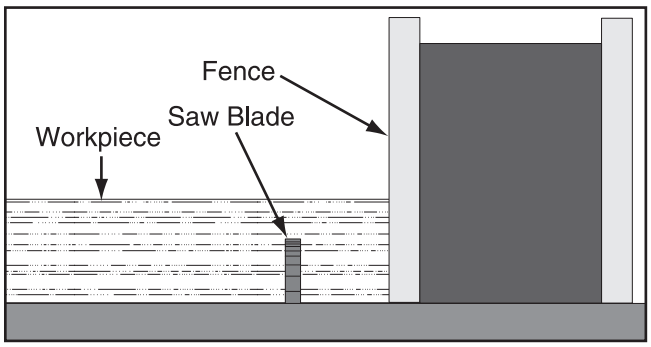


Figure 70. Example of a non-through cut.

Blade Guard

The term "blade guard" refers to the assembly shown in **Figure 71**.

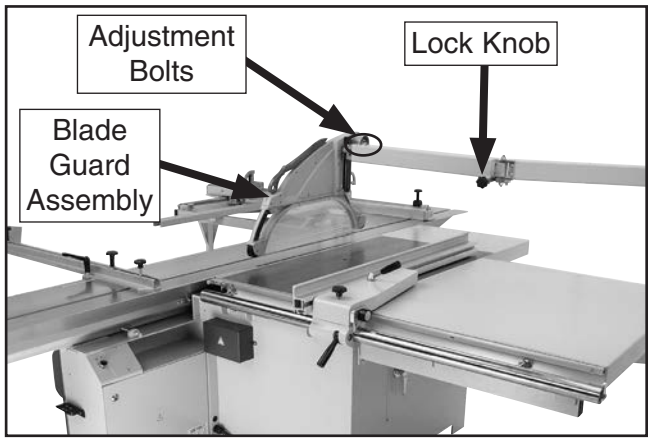


Figure 71. Blade guard assembly.

Understanding Blade Guard

The guard encloses the top of the blade to reduce the risk of accidental blade contact and to contain flying chips or dust. When installed and properly maintained, it is an excellent tool for reducing the risk of injury when operating the table saw.

To ensure that the guard does its job effectively, it MUST be centered over the blade and properly adjusted to accommodate workpieces and maintain coverage over the blade after the workpiece exits.

Adjusting Blade Guard

Loosen the adjustment bolts (see **Figure 71**) and adjust the guard so the distance between the blade and both side covers is equal, then re-tighten the bolts.

Manually raise or lower the blade guard so the distance from the table is equal to the thickness of the workpiece.

Every time the blade guard is re-installed, you must verify that it functions correctly before making a cut.

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating Saw

a) Wear eye protection.
b) Use saw-blade guard for every operation for which it can be used.
c) Keep hands out of the line of saw blade.
d) Use a push-stick when required.
e) Pay particular attention to instructions on reducing risk of kickback.
f) Do not perform any operation freehand.
g) Never reach around or over saw blade.

When to Use Blade Guard

In general, the blade guard MUST be installed on the saw for all cuts (see **Owner's Manual** on **Page 14**).

Sometimes the guard or its components can get in the way when cutting very narrow workpieces or during other specialized cuts. Loosen the lock knob shown in **Figure 71** all the way to move the guard out of the way. Because the guard is provided to decrease your risk of injury, it should not be used if it gets in the way of making a safe cut. Use good judgment!

The blade guard MUST remain installed on the saw, unless a specific operation requires its removal. If the blade guard is removed for specific operations, always immediately replace it after those operations are complete.

Changing Blade Guard Covers

The blade guard can be configured for straight cuts or angled cuts. Use the flat blade cover when performing straight cuts and the bubble cover for angled cuts.

To change blade guard covers:

1. Move slide lock (see **Figure 72**) to Open position to unlock blade guard cover.

2. Pull blade guard cover toward front of machine to remove (see **Figure 72**).

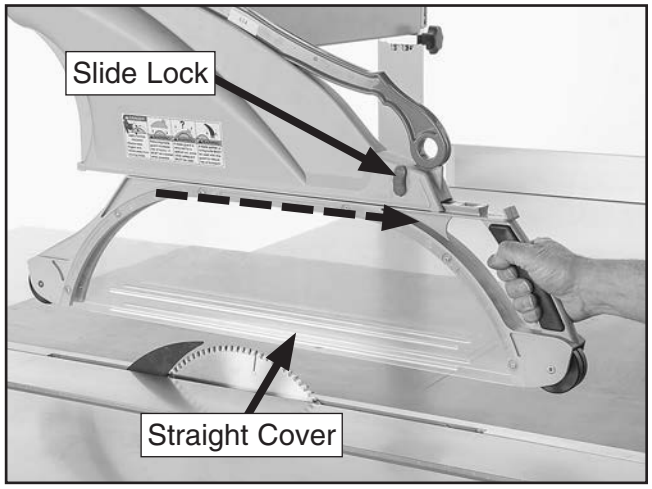


Figure 72. Changing blade guard cover.

3. Slide new blade guard cover all the way into slot, and move slide lock down to Lock position.

Riving Knife

The riving knife (see **Figure 73**) is a metal plate that helps prevent the freshly cut pieces of the workpiece from pinching the backside of the blade and causing a kickback. It also acts as a barrier behind the blade to shield hands from being pulled into the blade if a kickback occurs and the operator is reaching behind the blade. (Reaching behind blade is a major safety risk and should never be done.) Use the riving knife for all operations.

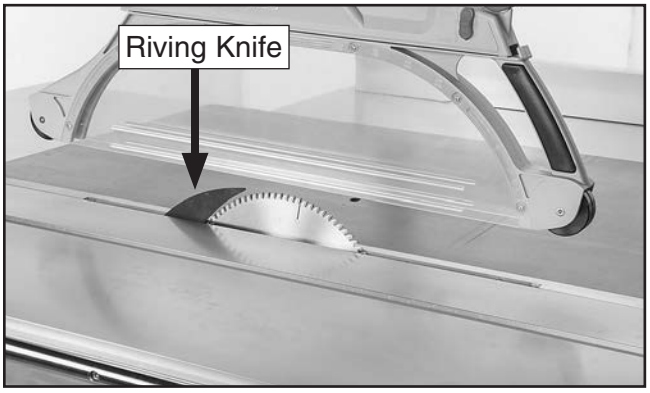


Figure 73. Riving knife location.

Riving Knife Installation & Removal

The riving knife must be correctly installed and adjusted in order to provide the maximum safety benefit.

The riving knife attaches to the mounting block as shown in **Figure 74**. Always firmly tighten the hex bolt when securing the riving knife in place.

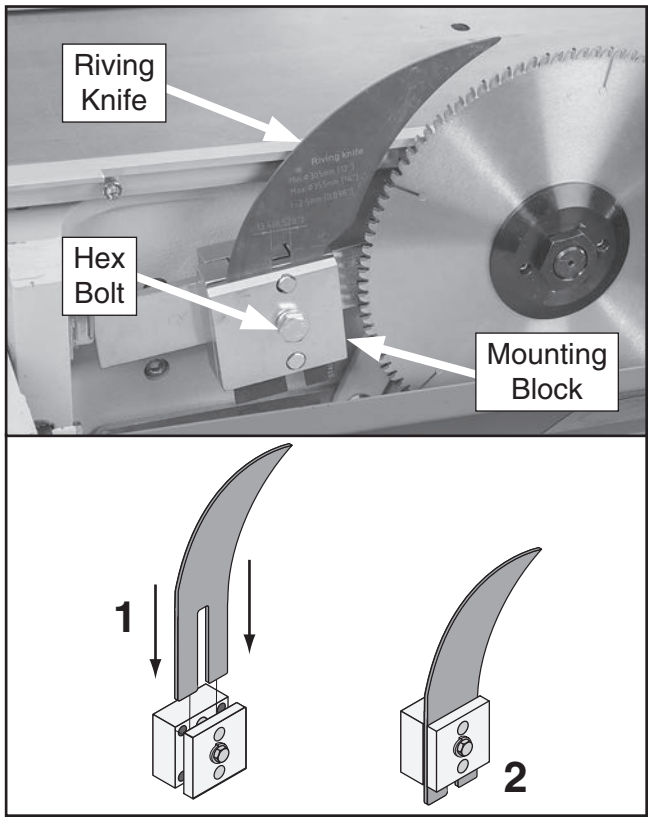


Figure 74. Installing riving knife on mounting block.

Secure the riving knife so that the top of it is 1–5mm below the top level of the blade, as shown in **Figure 75**.

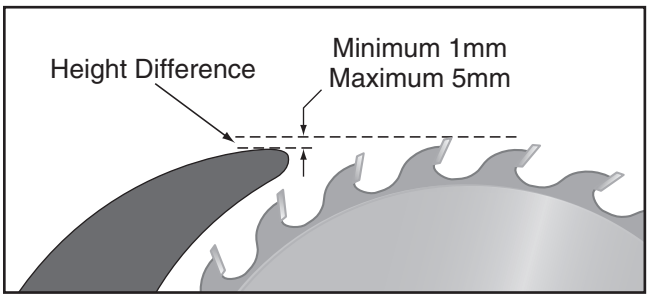


Figure 75. Height difference between riving knife and blade.

The height difference between the riving knife and the blade allows the workpiece to pass over the blade during non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

The riving knife also prevents the freshly cut sides of the workpiece from pinching the blade and causing kickback. For maximum effectiveness of this safety design, the riving knife must be positioned within 3–8mm of the blade, as shown in **Figure 76**.

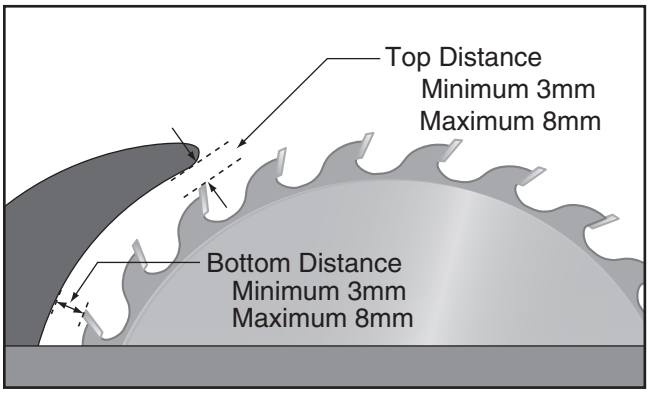


Figure 76. Allowable top and bottom distances between riving knife and blade.

Blade Requirements

The riving knife included with this machine is 0.098" (2.5mm) thick and is only designed for 12" and 14" diameter blades.

When choosing a main blade, make sure the blade size meets the requirements listed below. The thickness of the blade body and teeth can be measured with calipers or any precision measuring device.

Blade Size Requirements:
- Body Thickness: 0.108" (2.74mm)
- Kerf (Tooth) Thickness: 0.108" (2.74mm)

Blade Selection

This section on blade selection is by no means comprehensive. Always follow the saw blade manufacturer's recommendations to ensure safe and efficient operation of your table saw.

Ripping Blade Features:
- Best for cutting with the grain
- 30-40 teeth
- Flat-top ground tooth profile
- Large gullets for large chip removal

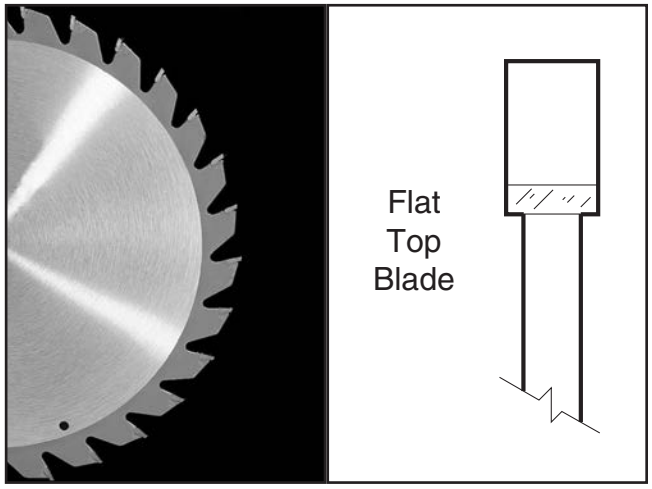


Figure 77. Ripping blade.

Crosscut blade features:
- Best for cutting across the grain
- 80–100 teeth
- Alternate top bevel tooth profile
- Small hook angle and a shallow gullet

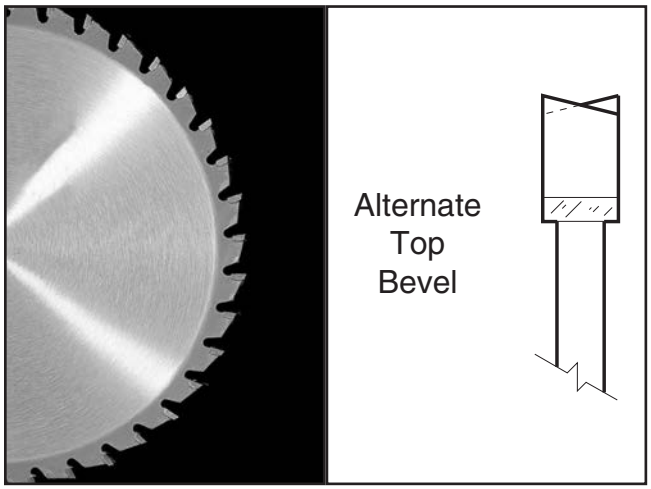


Figure 78. Crosscutting blade.

Combination blade features:
- Designed to cut both with and across grain
- 50–80 teeth
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile
- Teeth are arranged in groups
- Gullets are small and shallow (similar to a cross-cut blade), then large and deep (similar to a ripping blade

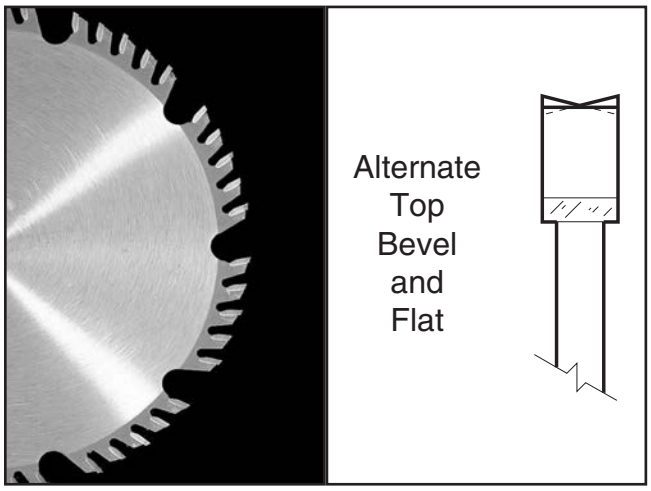


Figure 79. Combination blade.

Laminate blade features:

- Best for cutting plywood or veneer
- 100–120 teeth
- Triple chip tooth profile
- Very shallow gullet

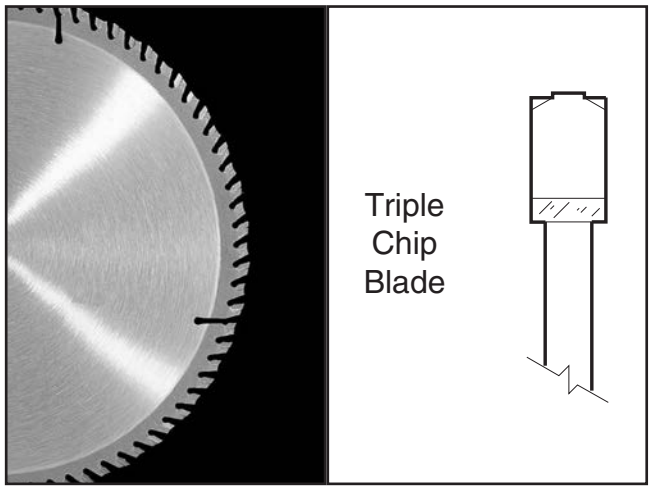


Figure 80. Laminate blade.

Thin Kerf Blade: A blade with thinner kerf than a standard blade. Since the spreader/riving knife included with this table saw is sized for standard blades, thin kerf blades cannot be used on this saw.

Changing Blade Angle

The main blade can be tilted from 0° – 45° using the keypad shown in **Figure 81**.

To set blade angle:

1. Turn main power switch to ON position.
2. Rotate EMERGENCY STOP button clockwise until it pops out.
3. Press SET on keypad (see **Figure 81**).

Figure 81. Blade angle controls.

4. Type in desired blade angle. (For example: if you want to set blade at 30°, type "3", "0".)
5. Press START on keypad. Blade should move to desired angle.

   Note: *To manually increase or decrease the blade angle in increments of 0.1°, use the + and - buttons shown in* ***Figure 81****.*

Changing Blade Height

The main blade and scoring blade are raised and lowered by pressing the UP and DOWN buttons shown in **Figure 82**.

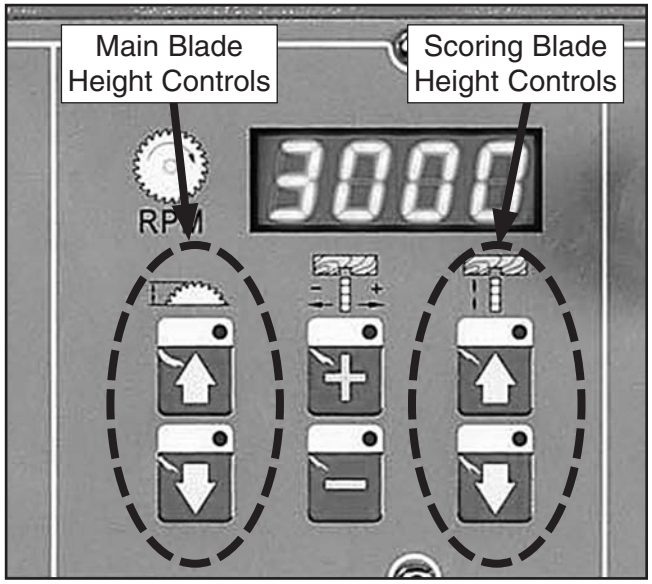


Figure 82. Location of blade height controls.

Changing Blade Speed

This machine has four main blade speeds—3000, 4000, 5000, and 6000 RPM. These speeds are selected by repositioning the main motor V-belt on the pulleys.

To change main blade speed:

1. DISCONNECT MACHINE FROM POWER!

2. Remove cap screws on top and bottom left corners of motor cabinet door, then open door.

3. Loosen lock handle shown in **Figure 83**.

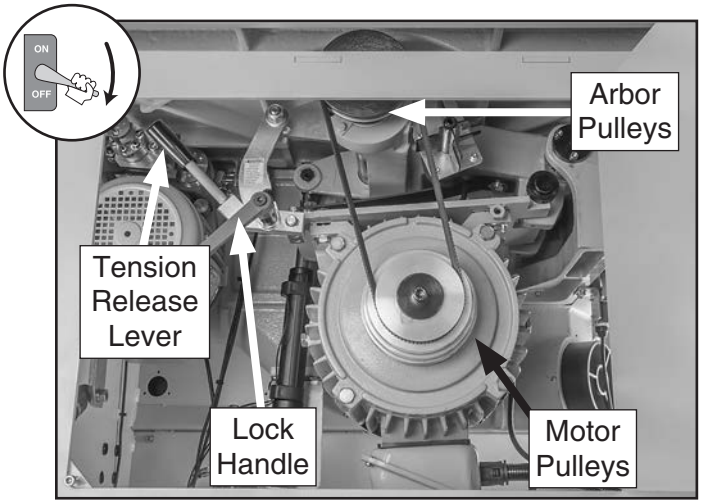


Figure 83. Main motor V-belt tension controls.

4. Move tension release lever down until it snaps into place, raising motor, releasing tension on V-belt (see **Figure 84**).

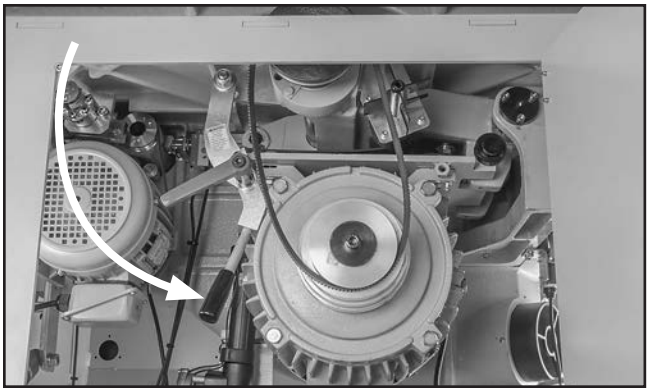


Figure 84. Main motor V-belt tension released.

5. Inspect belt. If there is any evidence of damage or excessive wear, replace with a new belt.

6. Position belt on appropriate pulley sheaves for desired bald speed (refer to **Figure 85** for pulley identification).

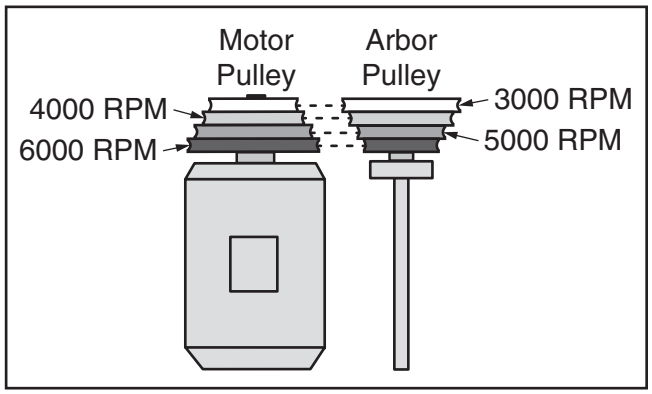


Figure 85. Belt positions for each blade speed.

7. Rotate pulley speed switch (**Figure 86**), so opening in fins lines up with belt position. This switch registers belt position with control panel.

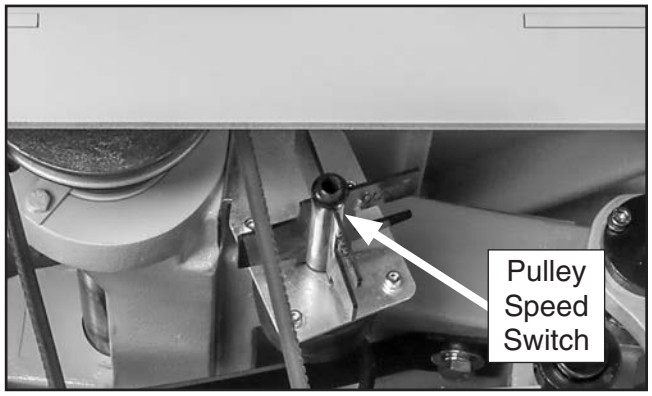


Figure 86. Location of pulley speed switch (near main blade arbor pulley).

8. Move tension release lever all the way up, allowing motor to pivot down and re-tension V-belt.

9. Re-tighten lock handle loosened in **Step 3** to secure the setting.

10. Close motor cabinet door, and re-install cap screws from **Step 2** before reconnecting machine to power.

Changing Main Blade

The Model G0772 performs best when using sharp, high-quality blades. Whenever the blades become dull, sharpen or replace them.

Tools Needed	**Qty**
Open-End Wrench 41mm	1
Blade Locking Tool	1

To change main blade:

1. Adjust main blade tilt to 0° and raise it all the way up.

2. DISCONNECT MACHINE FROM POWER!

3. Raise blade guard all the way.

4. Move sliding table all the way left while pushing release knob shown in **Figure 87**. This allows sliding table to move beyond its normal limit to expose lower blade cover.

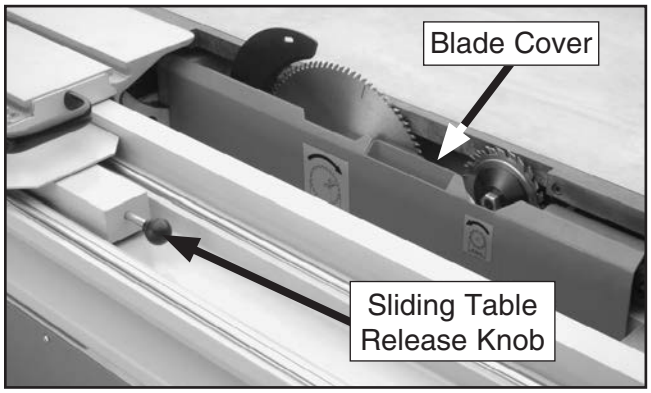
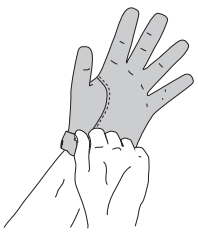


Figure 87. Sliding table release knob allows table to move farther than normal to expose lower blade cover.



⚠CAUTION

Saw blades are extremely sharp. Even dull blades can cause serious cuts when handled improperly. To reduce risk of injury, always wear leather gloves when working around blades.

5. Pull blade cover toward you to open it. It is held closed with magnets and just requires a firm tug to open.

6. Insert arbor locking tool into hole, as shown in **Figure 88,** and rotate blade by hand until tool drops into place.

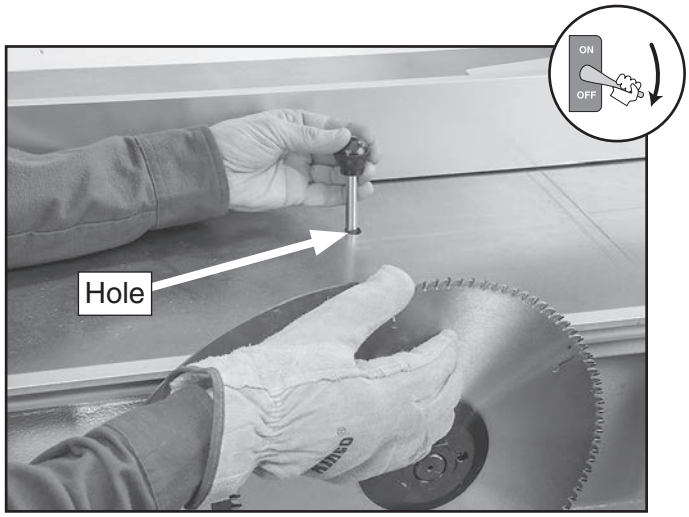


Figure 88. Using tool to lock main blade arbor for blade change.

7. Place rag over main blade to protect your hands from slipping into blade teeth, then loosen arbor nut by turning it clockwise (left-hand threads) to remove it, the flange, and the blade (see **Figure 89**).

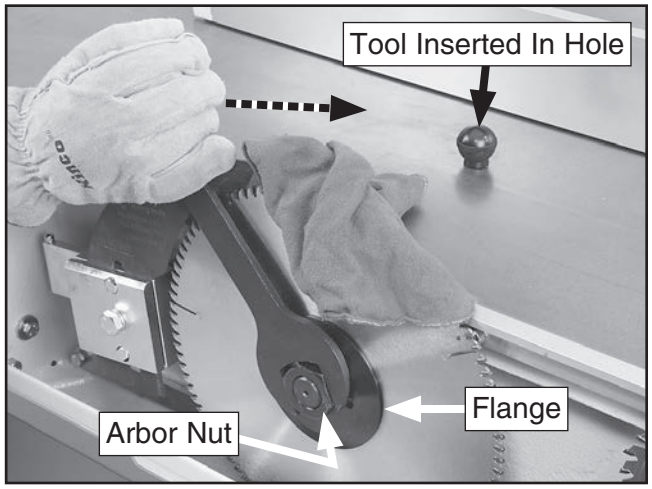


Figure 89. Rotating arbor nut clockwise to loosen when changing blade.

8. Install new blade, flange, and arbor nut in reverse order from removal, making sure upper blade teeth face RIGHT (see **Figure 90**), then tighten arbor nut.

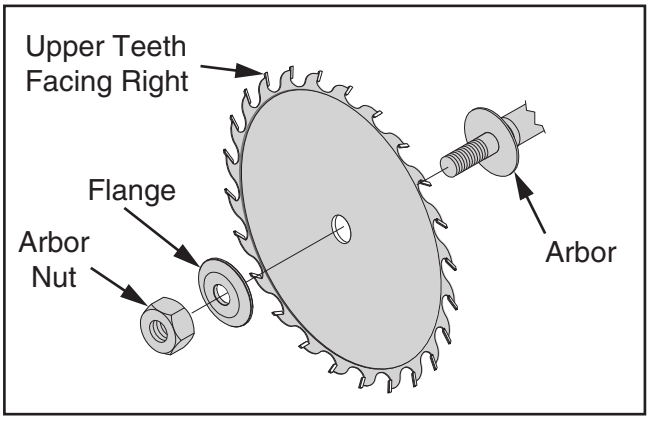


Figure 90. Order of assembly when installing main blade on arbor.

9. Remove blade locking tool from table hole.

10. Close lower blade cover, reposition blade guard over blade, then move sliding table back to center of machine.

11. Check scoring blade alignment with main blade, and adjust if necessary (see **Aligning Scoring Blade** on **Page 52**).

Replacing & Aligning Scoring Blade

The scoring blade rotates in the opposite direction of the main blade and makes a shallow cut in the workpiece surface to help prevent workpiece tear-out.

The scoring blade set included with the Model G0772 consists of an inner and outer blade with internal shims (see **Figure 91**). The shims are provided to match the scoring blade kerf with the kerf thickness of the main blade.

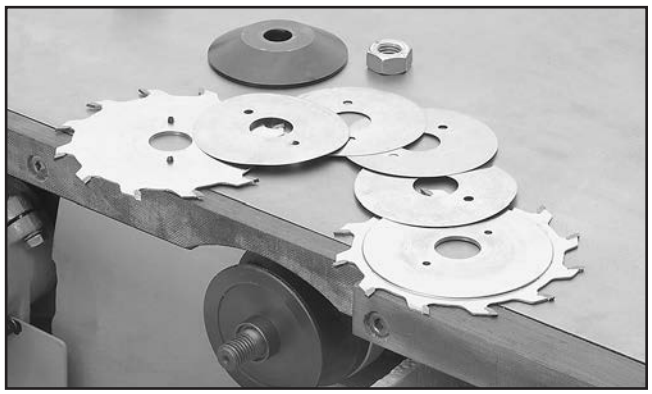


Figure 91. Example of scoring blade set with shims.

Replacing Scoring Blade

Tools Needed	Qty
Wrench 10mm	1
Wrench 22mm	1

To replace scoring blade:

1. Adjust blade tilt to 0° and raise both blades all the way up.
2. DISCONNECT MACHINE FROM POWER!
3. Raise blade guard and move it away from blade.
4. Move sliding table all the way forward, and open lower blade cover.
5. Place 10mm wrench around flats of arbor shaft, and use 22mm wrench to loosen arbor nut by turning counterclockwise (see **Figure 92**).

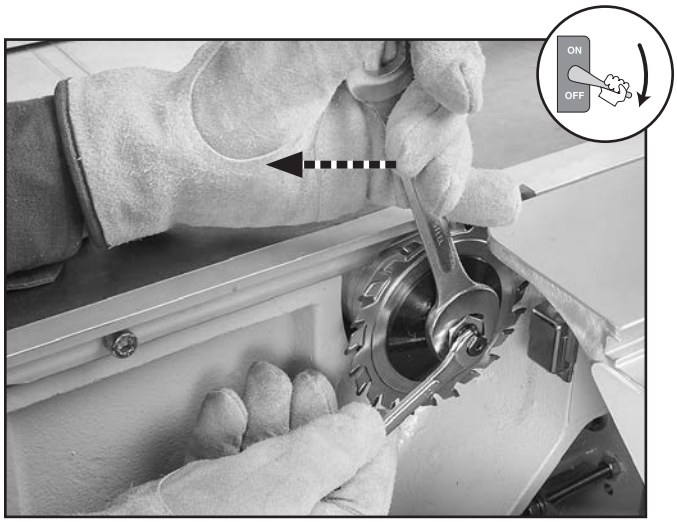


Figure 92. Scoring blade removal.

6. Remove arbor nut, flange, and scoring blade set.
7. Stack new scoring blade to same kerf thickness as main blade.

8. Install scoring blade set, flange, and arbor nut in reverse order from removal, making sure upper blade teeth face LEFT (see **Figure 93**), then tighten arbor nut.

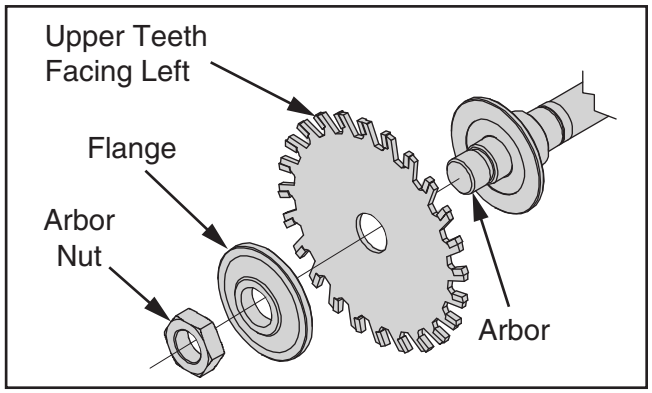


Figure 93. Scoring blade order of assembly.

9. Align scoring blade with main blade, as instructed in next subsection.

Aligning Scoring Blade

The scoring blade must be aligned with the main blade to properly prevent tear-out. Before attempting to align the blades with each other, the kerf thickness of the scoring blade must match that of the main blade.

To align scoring blade:

1. Adjust main blade tilt to 0°, then raise both blades all the way up.

2. Raise blade guard all the way and move it away from blade.

3. Loosen jam nut and remove outer rip fence stop screw shown in **Figure 94**. This allows rip fence to be positioned next to the blade.

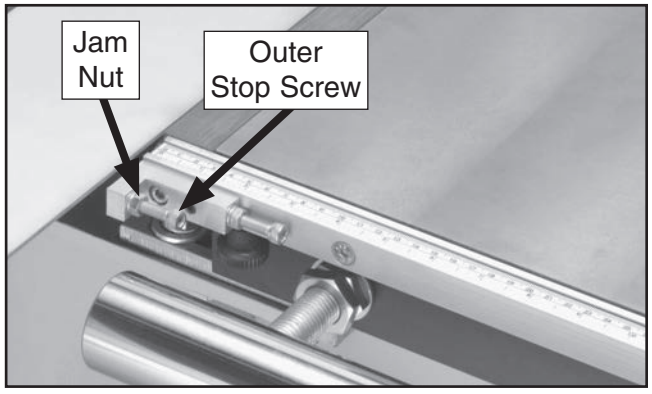


Figure 94. Location of rip fence jam nut and outer stop screw.

4. Move rip fence against main blade (or scoring blade), as shown in **Figure 95**.

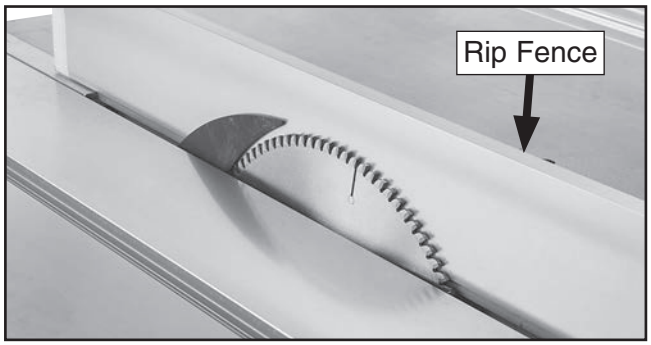


Figure 95. Rip fence against main blade as a guide for aligning scoring blade.

5. Use "+" and "-" keys on control panel to adjust scoring blade (see **Figure 96**) so that rip fence can touch both scoring blade and main blade evenly.

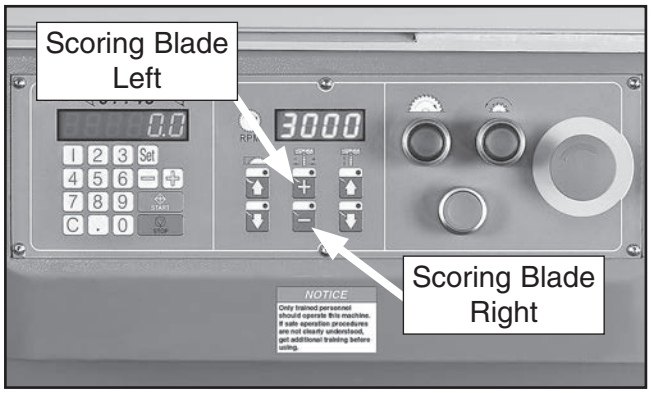


Figure 96. Scoring blade alignment controls.

6. Re-install stop screw removed in **Step 3**.

7. Reposition blade guard over blade.

8. Lower scoring blade to correct height. Perform test cut, then make any final adjustments, if necessary.

Setting Up Crosscut Fence

Before using the crosscut fence to perform cutting operations, it must be set up properly in order to make accurate cuts. This includes positioning the crosscut fence on the crosscut table, adjusting the support bar, adjusting the distance of the crosscut fence from the blade, and positioning the crosscut table along the sliding table.

Positioning Crosscut Fence

The crosscut fence can be mounted in the front or rear position (see **Figure 97**) depending on the size of the workpiece and which position will provide the safest operation. The support bar is adjusted accordingly for maximum workpiece support.

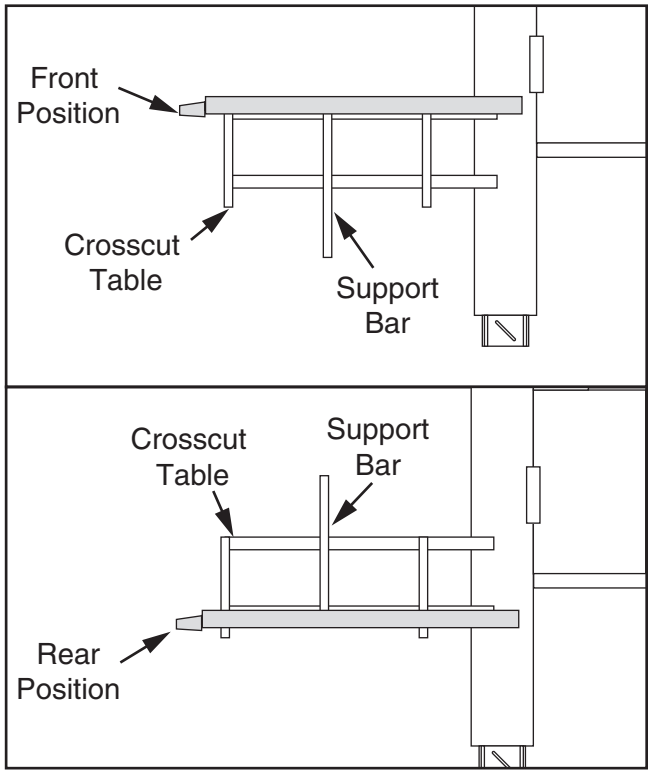


Figure 97. Crosscut fence front and rear table mounting positions.

To position crosscut fence:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen and disengage lock handles shown in **Figure 98**.

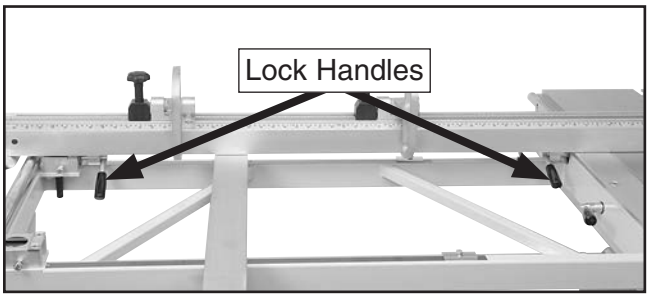


Figure 98. Location of lock handles that secure crosscut fence to crosscut table.

3. Lift fence up and place left guide pin in 90° slot, then place right guide pin in mounting hole in crosscut table (see **Figure 99**).

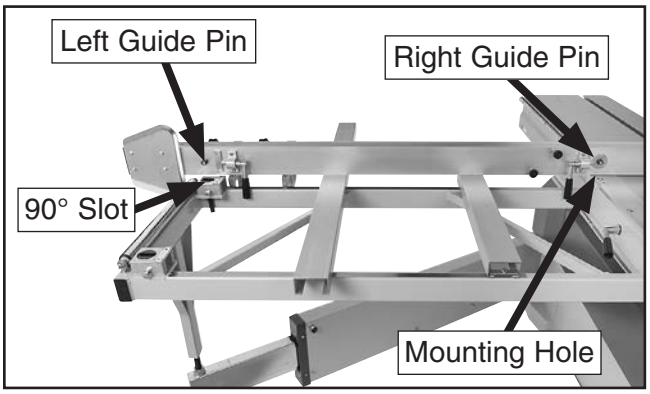


Figure 99. Crosscut fence pins and mounting locations.

4. Engage and tighten lock handles.

5. Loosen support bar lock knob shown in **Figure 100**, slide support bar into position required for operation, then tighten lock knob.

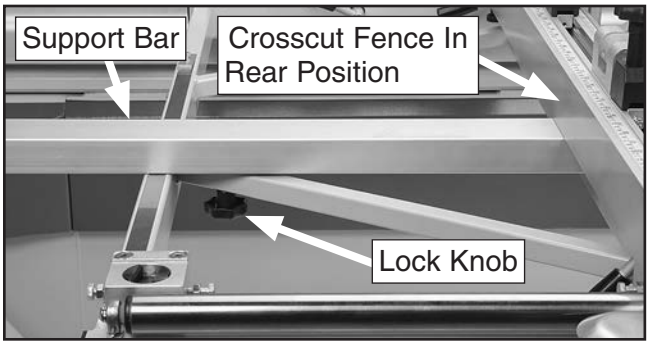


Figure 100. Location of lock knob that secures support bar to crosscut table.

Calibrating Crosscut Fence

To accurately use the crosscut fence scale and ensure the end-block does not contact the blade, the distance between the crosscut fence and the blade must be properly adjusted.

To adjust distance between crosscut fence and blade:

1. DISCONNECT MACHINE FROM POWER!

2. Move crosscut table (refer to **Positioning Crosscut Table Along Sliding Table** for instructions) so fence end block is aligned with center of blade (see **Figure 101**).

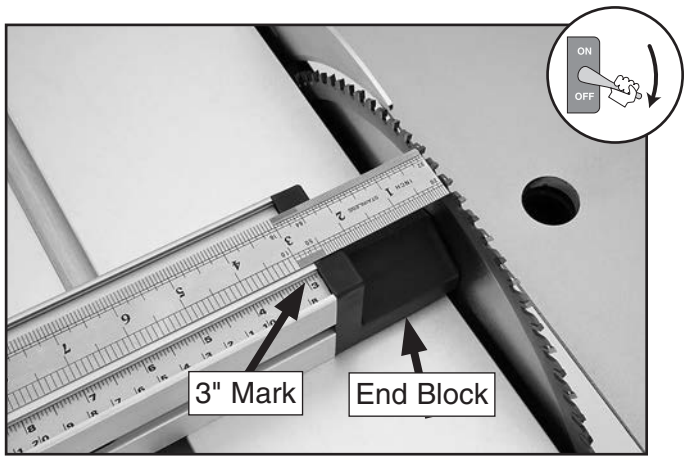


Figure 101. Example of fence scale calibration.

3. Loosen fence scale lock knob shown in **Figure 102**.

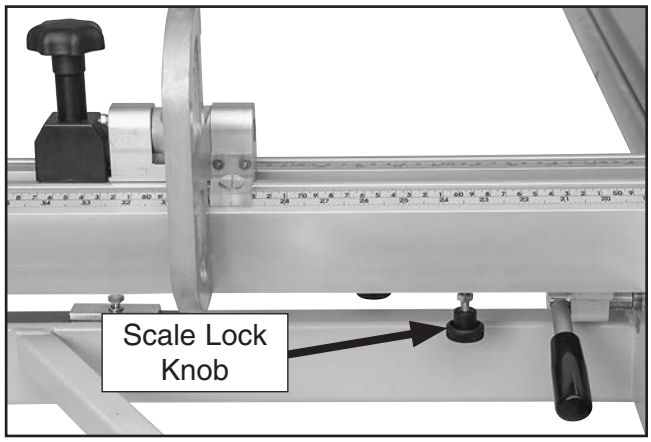


Figure 102. Location of fence scale lock knob.

4. Place precision ruler against a blade tooth, as shown in **Figure 101**, then adjust fence so that 3" mark on fence scale is exactly 3" from blade tooth, then re-tighten lock knob.

Positioning Crosscut Table Along Sliding Table

The crosscut table can be positioned as necessary along the sliding table (see **Figure 103**).

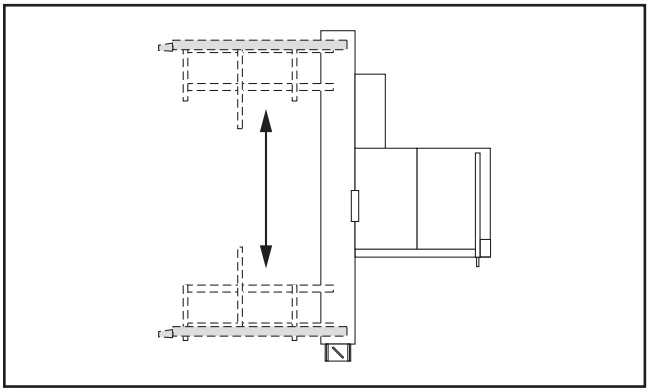


Figure 103. Crosscut table positions along sliding table.

To position crosscut table along sliding table:

1. DISCONNECT MACHINE FROM POWER!

2. Secure sliding table position with lock lever (see **Figure 104**).

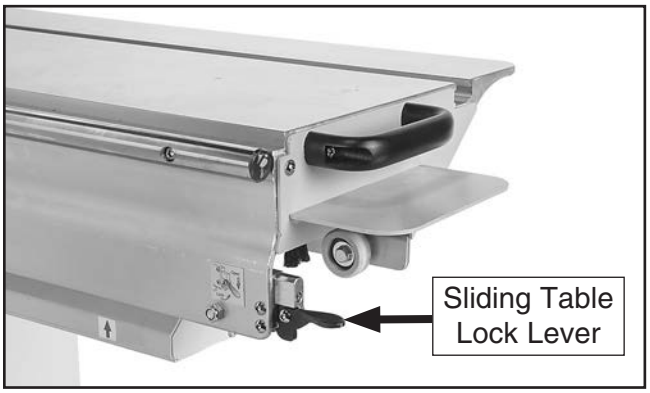


Figure 104. Location of sliding table lock lever.

3. Loosen crosscut table lock lever (**Figure 105**).

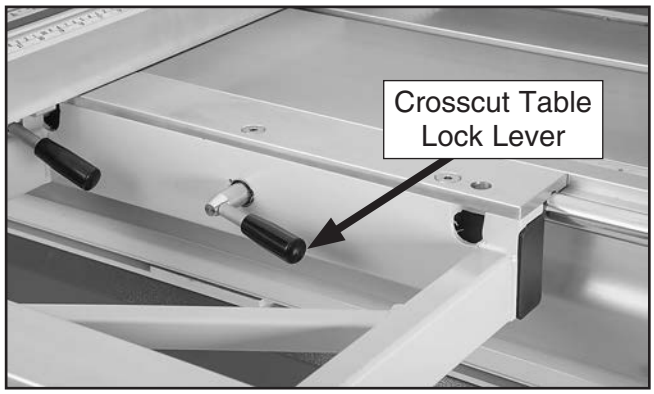


Figure 105. Location of crosscut table lock lever.

4. Position crosscut table along sliding table to desired position, then re-tighten lock lever to secure table.

Rip Cutting

The Model G0772 has the capability of rip cutting large panels (see **Figure 106**). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

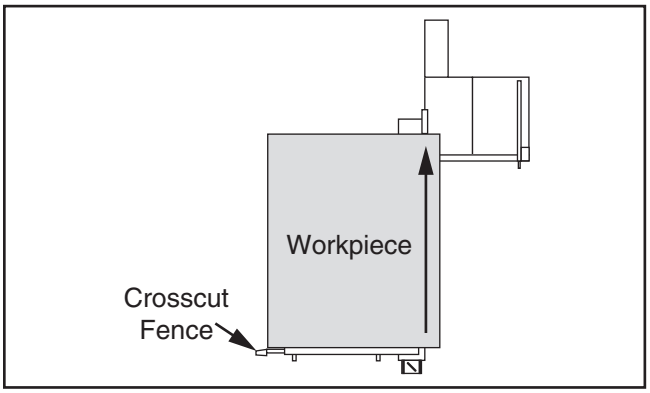


Figure 106. Rip cut with sliding table and crosscut fence.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (see **Figure 107**). Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.

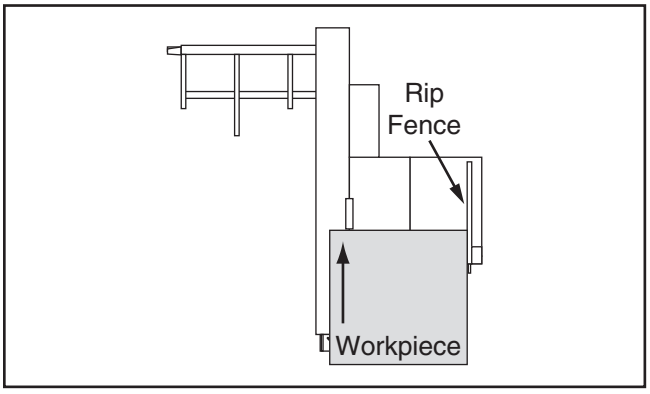


Figure 107. Traditional rip cut with rip fence.

Determine which cutting operation will be best suited for the workpiece to be ripped.

- To use the sliding table, read the instructions titled “Rip Cutting with Sliding Table.”
- To use the machine as a traditional table saw, skip ahead to “Rip Cutting with Rip Fence.”

Rip Cutting with Sliding Table

1. Position crosscut fence on crosscut table according to cutting operation (see **Setting Up Crosscut Fence** on **Page 53**).

2. Check to make sure fence is at 0°. If necessary, adjust it as described in **Squaring Crosscut Fence to Blade,** on **Page 84**.

3. Calibrate crosscut fence (refer to **Page 54** for further details).

4. Set a flip stop to desired width of cut (see **Figure 108**) by loosening flip stop knob bolt, sliding flip stop until it aligns with desired mark on scale, and retightening knob bolt.

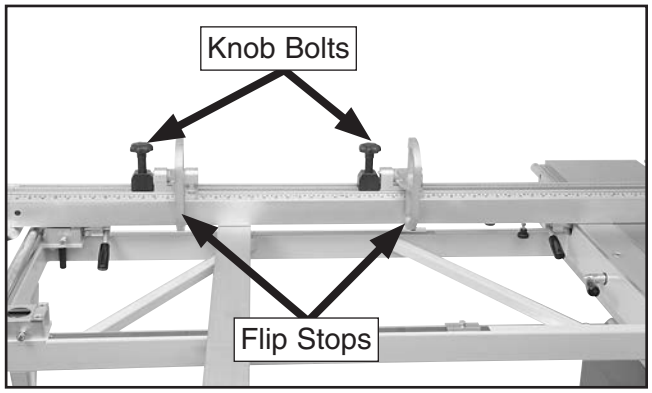


Figure 108. Location of flip stops and flip stop knob bolts.

5. Position blade guard according to height of workpiece.

6. Load workpiece onto table saw. Setup should look similar to **Figure 106**.

7. Take all necessary safety precautions, then perform cutting operation.

Rip Cutting with Rip Fence

1. Move crosscut table and fence to front of sliding table, and lock them in place with crosscut table lock lever (see **Figure 109**).

Figure 109. Location of crosscut table lock lever.

2. Lock sliding table in place with table lock lever (see **Figure 110**).

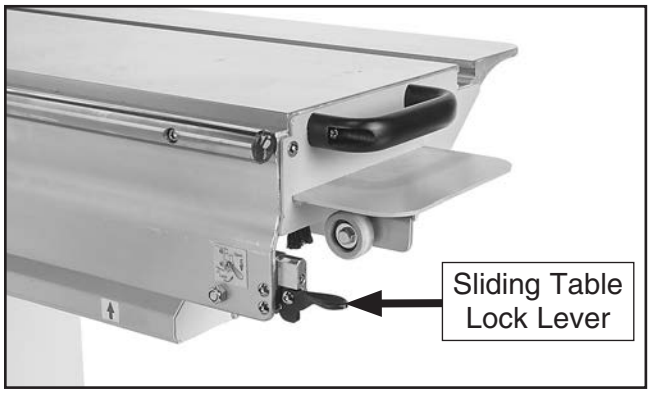


Figure 110. Location of sliding table lock lever.

3. Loosen slide lock lever shown in **Figure 111**.

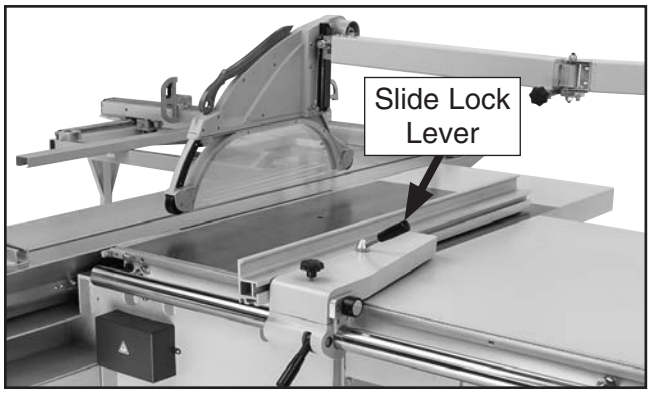


Figure 111. Location of slide lock lever.

4. Place fence in vertical position (see **Figure 112**) for thicker workpieces, or in horizontal position for thinner workpieces and for angled cuts where blade is tilted over fence.

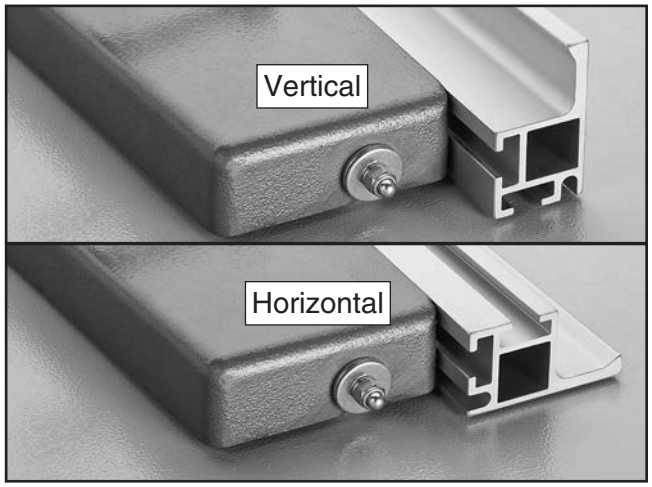


Figure 112. Example of rip fence positions.

5. Position leading edge of rip fence so it extends across extension wing, as shown in **Figure 113**, then retighten lock lever.

6. Lift rip fence lock lever (see **Figure 113**) and adjust fence to approximate width of cut.

7. Tighten micro-adjust lock knob (see **Figure 113**), then turn micro-adjust knob to fine tune width of cut.

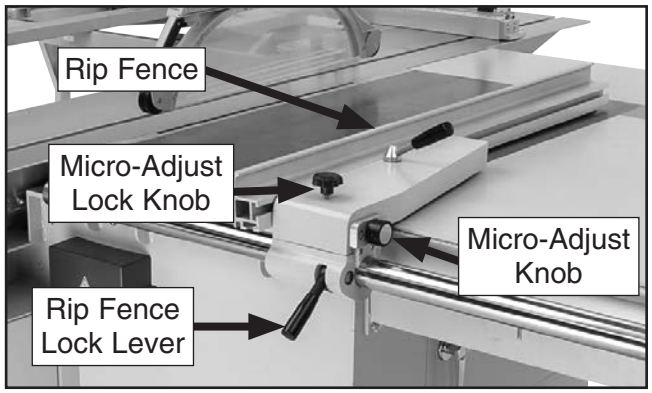


Figure 113. Proper position of rip fence.

8. Push rip fence lock lever down to secure fence assembly in position.

9. Load workpiece onto table saw. Setup should look similar to **Figure 107** on **Page 55**.

10. Take all necessary safety precautions, then perform cutting operation.

Crosscutting

The crosscut fence mounts in the front or rear position, although it is easier to load full-size panels with the crosscut fence in the front position (see **Figure 114**).

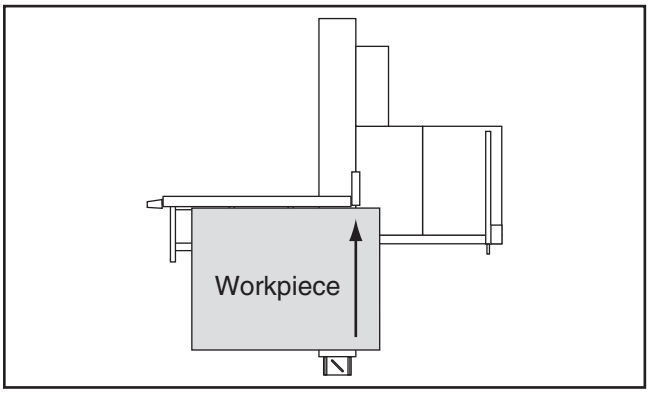


Figure 114. Crosscutting with fence mounted in front position.

Mounting the crosscut fence in the rear position (see **Figure 115**) gives greater stability for crosscutting smaller panels.

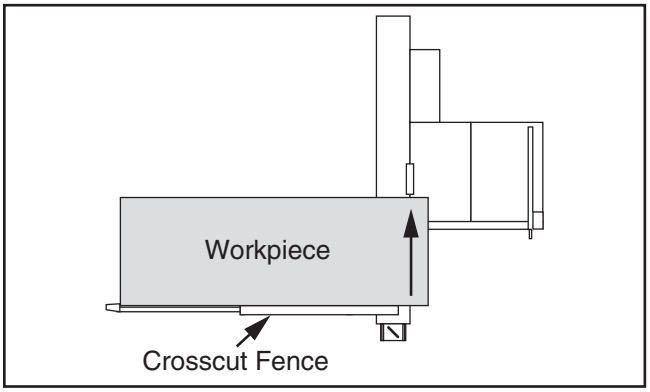


Figure 115. Crosscutting with fence mounted in rear position.

Continued on next page ➔

When set up properly, the crosscut fence can support workpieces while using the rip fence as a cut-off gauge, as shown in **Figure 116**.

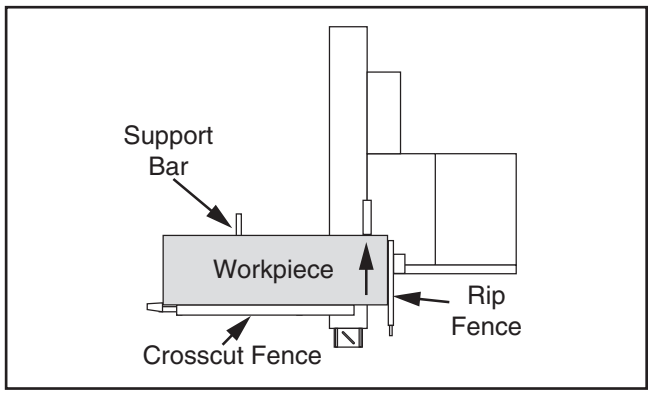


Figure 116. Crosscutting using the rip fence as a cut-off gauge.

Determine which cutting operation will be best suited for the workpiece to be crosscut.

—If you will be crosscutting full-size panels, then skip ahead to **Crosscutting Full-Size Panels**.

—If you will be crosscutting smaller panels, then skip ahead to **Crosscutting Smaller Panels**.

—If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to **Crosscutting Using Rip Fence as Cut-Off Gauge**.

To understand how to move the crosscut table, read **Positioning Crosscut Table Along Sliding Table** on **Page 54**.

Crosscutting Full-Size Panels

1. Install crosscut fence in front mounting location shown in **Figure 117**.

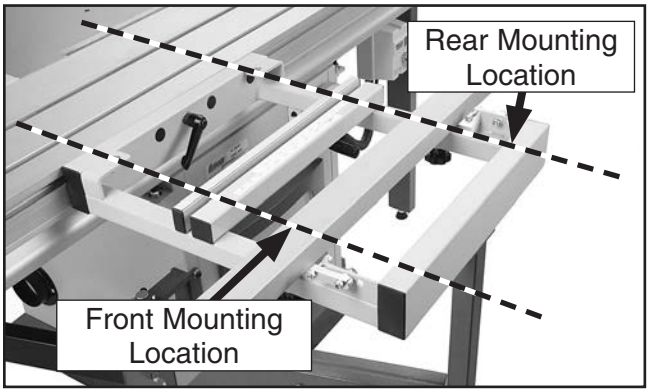


Figure 117. Example of crosscut fence mounting locations.

2. Check to make sure fence is at 0°, and if necessary, adjust it as described on **Page 84**.

3. Adjust distance between crosscut fence and blade (refer to **Page 54** for further details).

4. Set either flip stop to desired width of cut.

   Note: *Extend the crosscut fence slide if workpiece is more than 66".*

5. Load workpiece onto table saw in front mounting location (see **Figure 114** on **Page 57**).

6. Take all necessary safety precautions, then perform cutting operation.

Crosscutting Smaller Panels

1. Install crosscut fence in rear mounting location shown in **Figure 117** and lock it in place.

2. Perform **Steps 2–4** in **Crosscutting Full-Size Panels.**

   Note: *Extend the crosscut fence slide if workpiece is more than 66".*

3. Load workpiece onto table saw in rear mounting location, shown in **Figure 115** on **Page 57**.

4. Take all necessary safety precautions, then perform cutting operation.

Crosscutting Using Rip Fence as Cut-Off Gauge

1. Install crosscut fence in rear position of crosscut table, as illustrated in **Figure 116** on **Page 58**.

2. Perform **Steps 2–4** in **Crosscutting Full-Size Panels.**

3. Set rip fence to desired width of cut.

4. Slide leading end of rip fence behind front edge of blade (see **Figure 118** for an example).

   Important: *This step is critical to reducing the risk of blade binding and kickback.*

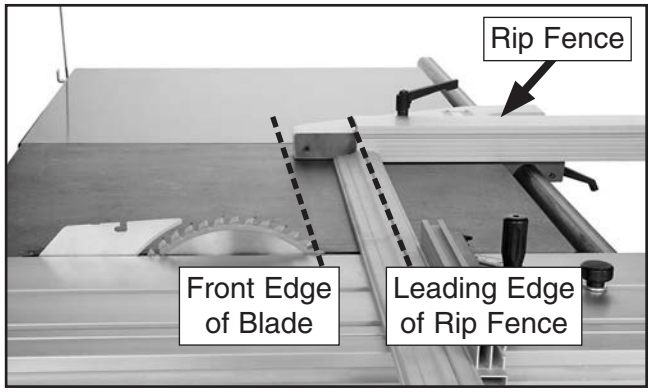


Figure 118. Example photo of correct rip fence position when using it as a cut-off gauge (blade guard removed for clarity).

5. Load workpiece onto table saw and against rip fence. Setup should look similar to **Figure 118**.

6. Take all necessary safety precautions, then perform cutting operation.

Miter Cutting

The miter fence allows miter cuts from 30˚ through 135˚ on workpieces ranging in length from 9½" through 83". The table-mounted miter scale has a resolution of ½˚.

The flip stop can be slid into either end of the the miter fence to accommodate different cut -off lengths.

The short end allows the flip stop to be positioned closer to the blade for cut-off lengths under 45", while the long end allows positions farther from the blade for cut-off lengths over 45", as shown in **Figures 119–120**.

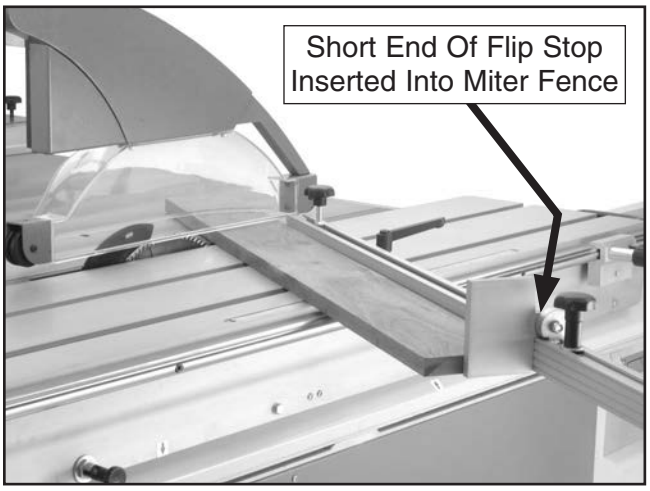


Figure 119. Example of miter cutting operation for a cut length less than 45".

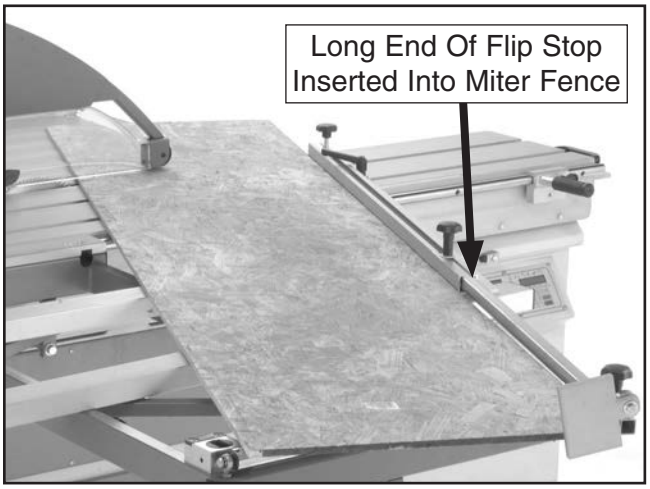


Figure 120. Example of miter cutting operation for a cut length over 45".

To perform miter cut:

1. Mount miter fence onto sliding table (refer to **Step 37** on **Page 32**).

2. Position fence at desired angle and use clamp plate ratcheting handle to lock fence in place (see **Figure 121**).

Figure 121. Miter fence set to 45˚ mark on the miter fence scale.

3. Loosen lock knobs that secure flip stop in miter fence (see **Figure 122**).

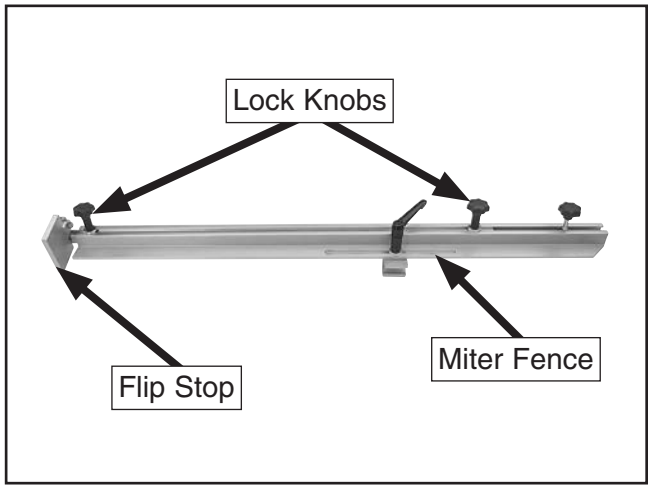


Figure 122. Location of flip stop lock knobs.

4. Position flip stop to left of blade according to length of workpiece.

   — If desired cut-off length to left of blade is between 9½" and 45", then insert short end of flip stop into miter fence body (see **Figure 123**).

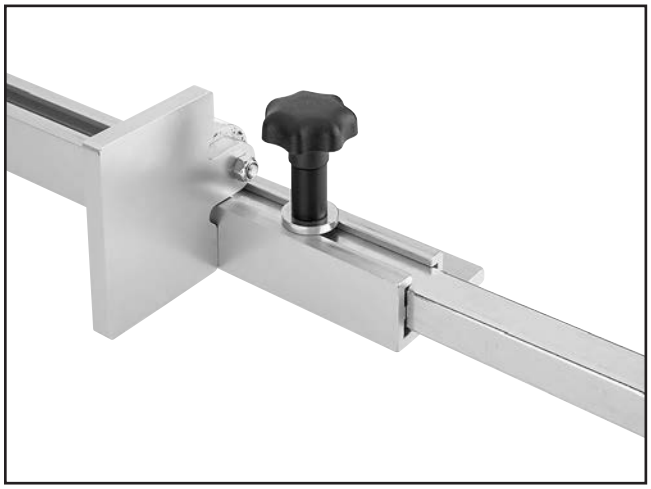


Figure 123. Flip stop installation for cut length between 9½" and 45".

   — If desired cut-off length to left of blade is between 45" and 83", then insert long end of flip stop into miter fence body (see **Figure 124**).

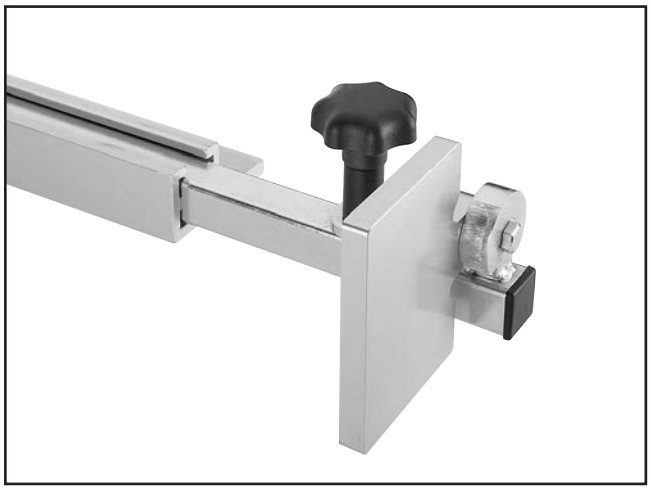


Figure 124. Flip stop installation for cut length between 45" and 83".

5. Position blade guard to correct height for your workpiece.

6. Load workpiece onto table saw. Setup should look similar to **Figure 119** or **120** on **Page on this page**.

7. Once all necessary safety precautions have been taken, perform cutting operation.

Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece.

Typically, dadoes can be cut using either a dedicated dado blade or a standard saw blade. However, since the Model G0772 cannot accept dado blades, a standard blade must be used.

To use standard saw blade to cut a dado:

1. Mark width of dado cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is lying on table.

2. Raise blade to desired depth of dado channel.

3. Align workpiece with blade to cut one dado side, as shown in **Figure 125**, then align rip fence with workpiece.

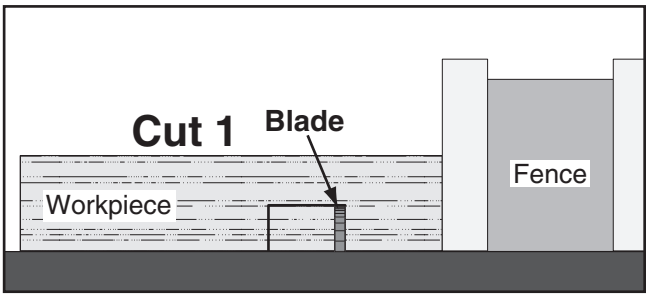


Figure 125. First cut for a single-blade dado.

4. Turn saw ***ON***.

5. Allow blade to reach full speed, then perform cutting operation.

6. Repeat cutting operation on other side of dado channel, as shown in **Figure 126.**

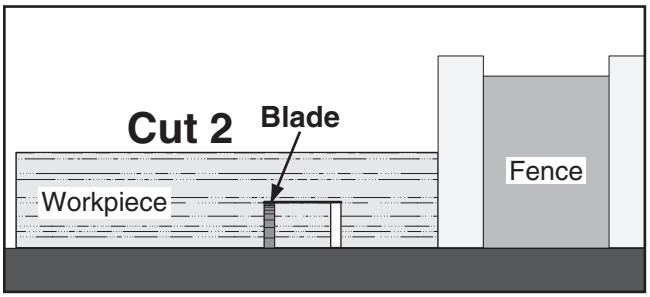


Figure 126. Second cut for a single-blade dado.

7. Make additional cuts (see **Figure 127**) in center of dado to clear out necessary material. Dado is complete when channel is completely cleared out.

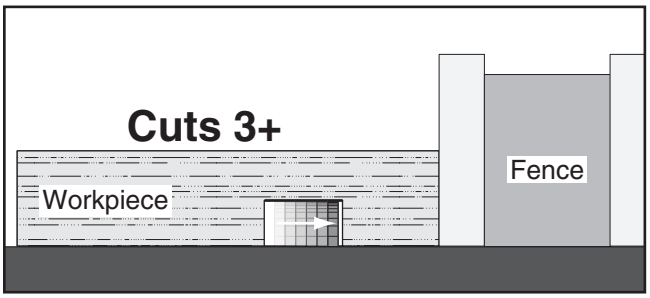


Figure 127. Additional single-blade dado cuts.

⚠WARNING

Adjust rip fence to properly support workpiece for each of the dado cuts. This will reduce likelihood of kickback and injury.

Rabbet Cutting

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece.

Typically, rabbets can be cut with either a dado blade or a standard saw blade. However, because the Model G0772 cannot accept dado blades, rabbets must be cut with a standard saw blade only.

A ripping blade is typically the best blade to use for cutting rabbets when using a standard blade because it removes sawdust very efficiently. (See **Page 46** for blade details.) Also, a sacrificial fence is not required when cutting rabbets with a standard blade.

To cut rabbets with standard blade:

1. Mark width of rabbet cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is lying on table.

2. If workpiece is too tall to safely use blade guard, position blade guard up and away from main blade.

⚠CAUTION

Always use push sticks, featherboards, push paddles, and other safety accessories whenever possible to increase safety and control during operations which require removal of blade guard. ALWAYS replace blade guard after operation is complete.

3. Raise blade to desired depth of rabbet channel.

4. Stand workpiece on edge, as shown in **Figure 128,** then adjust rip fence so blade is aligned with inside of rabbet channel.

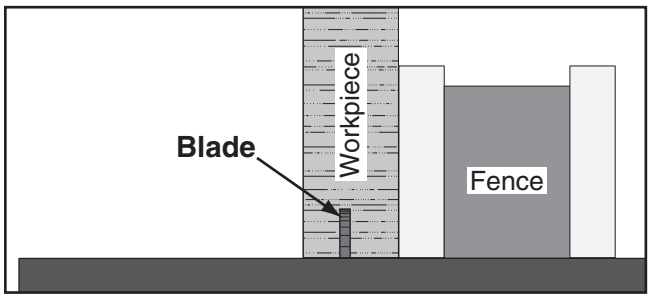
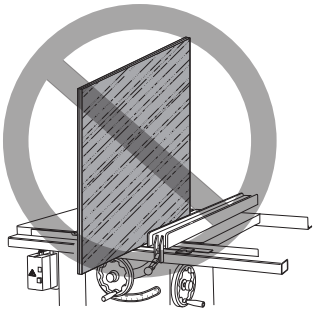


Figure 128. First rabbet cut.

⚠WARNING



DO NOT place a tall board on edge when cutting a rabbet. Overly tall workpieces cannot be properly supported with the fence and can easily shift during operation, causing kickback or loss of control. Instead, use another tool to cut these types of rabbets.

5. Turn saw ***ON*** and perform cut.

6. Lay workpiece flat on table, as shown in **Figure 129**, adjust saw blade height to intersect with first cut, then perform second cut to complete rabbet.

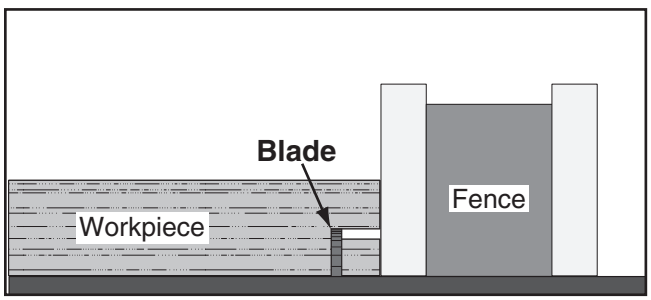


Figure 129. Second cut to create a rabbet.

Resawing

⚠WARNING

Resawing operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when resawing. Any tilting or movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

Resawing is the process of cutting a thick piece of stock into one or more thinner pieces. Although resawing can be done with a table saw, we strongly recommend that you use a bandsaw instead.

A bandsaw is the ideal machine for resawing, and resawing with one is fairly easy and safe. A table saw is not intended for resawing, and resawing with one is difficult and dangerous due to the increased risk of kickback from binding and deep cuts, and the increased risk of injury from having to remove the blade guard.

If you insist on resawing with a table saw, DO NOT do so without using a resaw barrier and wearing safety glasses and a full face shield.

The following instructions describe how to build a resaw barrier that can be used with the rip fence when resawing to reduce the risk of injury.

IMPORTANT: *This table saw can only resaw wood that is less than 8" tall, and the rip fence must be used (rather than the sliding table).*

Making a Resaw Barrier

The resaw barrier acts in tandem with the rip fence when resawing to provide tall support for the workpiece to minimize the probability of it binding against the blade and causing kickback.

Tools Needed:	**Qty**
Table Saw	1
Jointer and Planer	Recommended
Clamps	2 Minimum
Drill and Drill Bits	1

Components Needed for Resaw Barrier:

Wood* ¾" x 5½" x Length of Fence	1
Wood* ¾" x 3" x Length of Fence	1
Wood Screws #8 x 2"	8
Wood Glue	As Needed

**Only use furniture-grade plywood or kiln dried hardwood to prevent warping.*

To build resaw barrier:

1. Cut wood pieces to sizes specified above. If using hardwood, cut pieces oversize, then joint and plane them to correct size to make sure they are square and flat.

2. Pre-drill and countersink four holes approximately ⅜" from bottom of 5½" tall wood piece.

3. Glue end of 3" board, then clamp boards at a 90° angle with larger board in vertical position, as shown in **Figure 130**, and fasten together with wood screws.

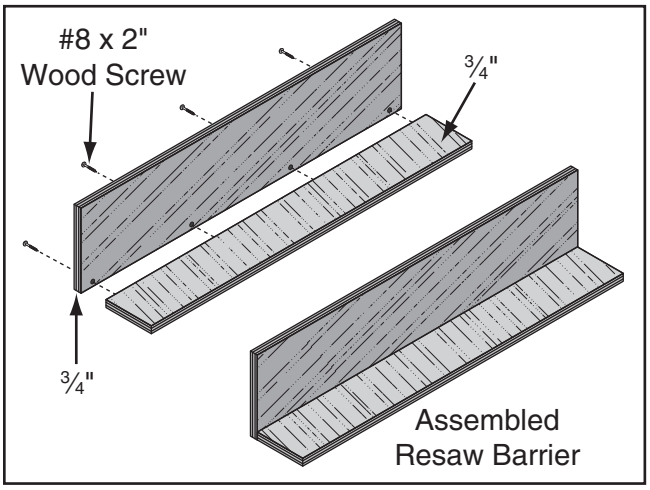


Figure 130. Resaw barrier.

Resawing Operations

The table saw motor is pushed to its limits when resawing. If the motor starts to bog down, slow down your feed rate. Motor overloading and blade wear can be reduced by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.

Components Needed for Resawing:

Ripping Blade 14"....1
Clamps 2
Shop-Made Resaw Barrier....1

⚠WARNING

You may experience kickback during this procedure. Stand to the side of the blade path and wear safety glasses and a full face shield to reduce risk of injury.

To perform resawing operations:

1. DISCONNECT MACHINE FROM POWER!
2. Raise blade guard up and out of the way.
3. Install rip fence in vertical position.
4. Place workpiece against rip fence and slide resaw barrier against workpiece (see **Figure 131**).

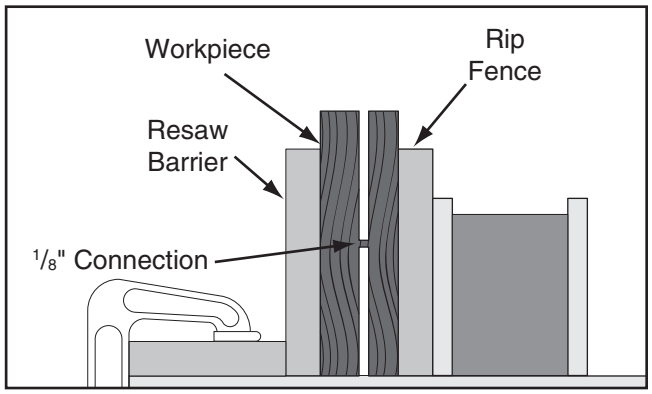


Figure 131. Ideal completed resaw cut.

5. Clamp resaw barrier to table top.
6. Connect saw to power, lower blade completely below table, and slide workpiece over blade to make sure it moves smoothly and fits between resaw barrier and rip fence.
7. Raise blade approximately 1", or close to half the height of the workpiece, whichever is less.
8. Turn machine ***ON***, and use a push stick to feed workpiece through blade using a slow, steady feed rate.
9. Flip workpiece end for end, keeping same side against rip fence, and run workpiece through blade.
10. Repeat **Steps 7–9** until blade is close to half the height of workpiece to be resawn.

    IMPORTANT: *The ideal completed resaw cut will leave approximately ⅛" connection when the resawing is complete, as shown in* ***Figure 131****. Leaving a ⅛" connection will reduce risk of kickback.*

11. Turn saw ***OFF***, then separate parts of workpiece and hand plane remaining ridge.
12. When finished resawing, remove resaw barrier and reposition blade guard over blade.

SECTION 5: SHOP MADE SAFETY ACCESSORIES

Featherboards

Easily made from scrap stock, featherboards provide an added degree of protection against kickback, especially when used together with push sticks. They also maintain pressure on the workpiece to keep it against the fence or table while cutting, which makes the operation easier and safer because the cut can be completed without the operator's hands getting near the blade. The angled ends and flexibility of the fingers allow the workpiece to move in only one direction.

Making a Featherboard

This sub-section covers the two basic types of featherboards: 1) Those secured by clamps, and 2) those secured with the miter slot.

Material Needed for Featherboard
Hardwood ¾" x 3" x 10" (Minimum)
Hardwood ¾" x 6" x 28" (Maximum) 1

Additional Material Needed for Mounting Featherboard in Miter Slot
Hardwood ⅜" x (Miter Slot Width) x 5"L 1
Wing Nut ¼"-20.....1
Flat Head Screw ¼"-20 x 2".....1
Flat Washer ¼"-20.....1

To make a featherboard:

1. Cut hardwood board approximately ¾" thick to size. The length and width of board can vary according to your design. Most featherboards are 10"–28" long and 3"–6" wide. Make sure wood grain runs parallel with length of featherboard, so fingers you will create in **Step 3** will bend without breaking.

2. Cut a 30° angle at one end of board.

CAUTION

We recommend using a bandsaw for making fingers in the next step because it tends to be safer. A table saw can be used, but it will over-cut the underside of the ends, produce a thicker kerf, and require you to stop the blade half-way through the cut, which can be dangerous.

3. Make a series of end cuts with grain ⅜"–¼" apart and 2"–3" long, as shown in **Figure 132** (A). Alternatively, start cuts at 2"-3" deep, then make them progressively deeper, as shown in **Figure 132** (B).

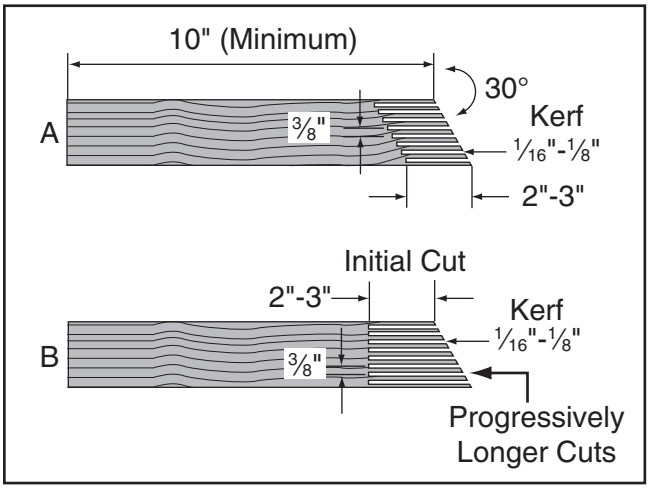


Figure 132. Patterns for featherboards (top view shown).

IMPORTANT: Cuts made across grain result in weak fingers that easily break when flexed. When made correctly, fingers should withstand flexing from moderate pressure. To test the finger flexibility, push firmly on the ends with your thumb. If the fingers do not flex, they are likely too thick (the cuts are too far apart).

NOTICE

Only Steps 1–3 are required to make a clamp-mounted featherboard. Refer to Page 67 for instructions on clamping.

4. Rout ¼"–⅜" wide slot 4"–5" long in workpiece and 1"–2" from short end of featherboard (see **Figure 133**).

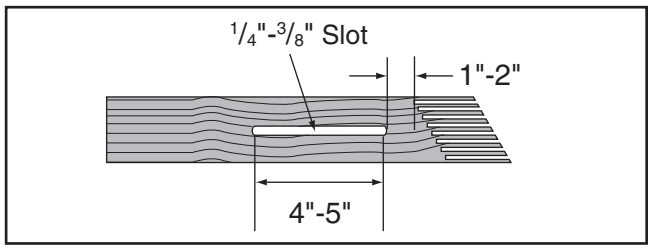


Figure 133. Slot routed in featherboard.

5. Cut miter bar that will fit in table miter slot approximately 5" long, as shown in **Figure 134**.

Tip: *Consider making the miter bar longer for larger featherboards—approximately half the length of the total featherboard—to support the force applied to the featherboard during use.*

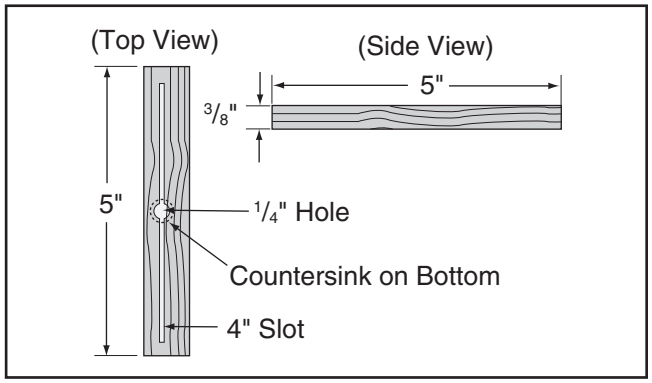


Figure 134. Miter bar pattern.

6. Drill ¼" hole in center of bar, then countersink bottom to fit ¼"-20 flat head screw.

7. Mark 4" line through center of countersunk hole in center, then use jig saw with narrow blade to cut it out.

8. Assemble miter bar and featherboard with ¼"-20 x flat head screw, flat washer, and a wing nut or a star knob (see **Figure 135**). Congratulations! Your featherboard is complete.

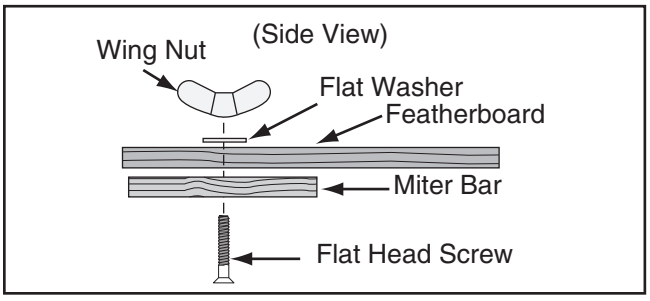


Figure 135. Assembling miter slot featherboard components.

Note: *The routed slot, countersink hole, and the flat head screw are essential for the miter bar to clamp into the miter slot. When the wing nut is tightened, it will draw the flat head screw upward into the countersunk hole. This will spread the sides of the miter bar and force them into the walls of the miter slot, locking the featherboard in place.*

Tip: *The length of the flat head screw depends on the thickness of the featherboard—though 1½" to 2" lengths usually work.*

Now, proceed to **Mounting Featherboard in Miter Slot** on **Page 67**.

Mounting Featherboards w/Clamps

1. Lower saw blade, then adjust fence to desired width and secure it.

2. Place workpiece against fence, making sure it is 1" in front of blade.

3. Place featherboard on table away from blade so all fingers point forward and contact workpiece (see **Figure 136**).

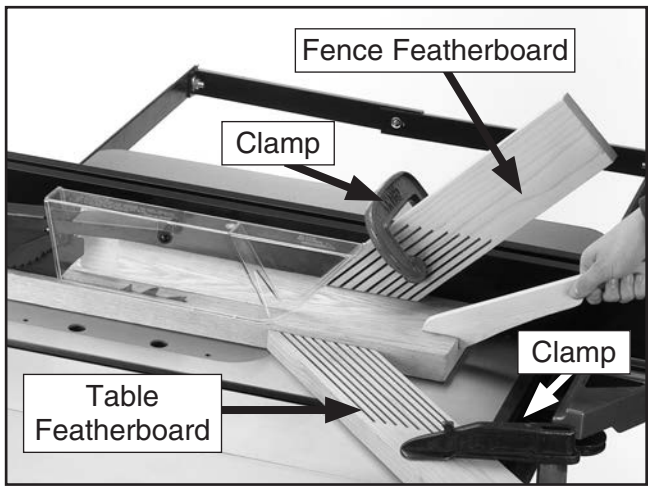


Figure 136. Example of featherboards secured with clamps.

4. Secure featherboard to table with clamp.

5. Check featherboard by pushing it with your thumb to ensure it is secure.

   —If featherboard moves, tighten clamp more.

6. Mount second featherboard to fence with another clamp (see **Figure 136**), then repeat **Step 5** to ensure it is secure.

Mounting Featherboard in Miter Slot

1. Lower saw blade, then adjust fence to desired width and secure it.

2. Place workpiece evenly against fence, making sure it is 1" in front of blade.

3. Slide featherboard miter bar into miter slot, making sure fingers slant toward blade, as shown in **Figure 137**.

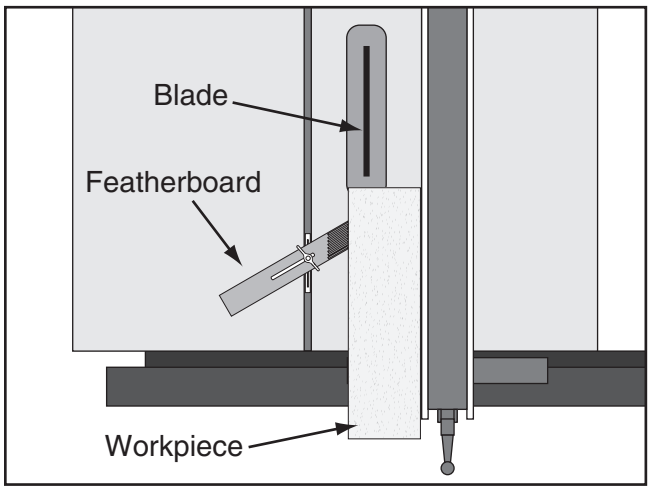


Figure 137. Featherboard installed in miter slot and supporting workpiece for ripping cut.

4. Position fingered edge of featherboard against edge of workpiece, so that all of fingers contact workpiece. Slide featherboard toward blade until first finger is nearly even with end of workpiece, which should be 1" away from blade.

5. Double check workpiece and featherboard to ensure they are properly positioned as described in **Step 4**. Then secure featherboard to table. Check featherboard by hand to make sure it is tight.

   Note: *The featherboard should be placed firmly enough against the workpiece to keep it against the fence but not so tight that it is difficult to feed the workpiece.*

Push Sticks

When used correctly, push sticks reduce the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push stick can also absorb damage that would have otherwise happened to hands or fingers.

Using a Push Stick

Use push sticks whenever your hands will get within 12" of the blade. To maintain control when cutting large workpieces, start the cut by feeding with your hands then use push sticks to finish the cut, so your hands are not on the end of the workpiece as it passes through the blade.

Feeding: Place the notched end of the push stick against the end of the workpiece (see inset **Figure** below), and move the workpiece into the blade with steady downward and forward pressure.

Supporting: A second push stick can be used to keep the workpiece firmly against the fence while cutting. When using a push stick in this manner, only apply pressure before the blade; otherwise, pushing the workpiece against or behind the blade will increase the risk of kickback (see "Push Stick Prohibition Zone" in the **Figure** below).

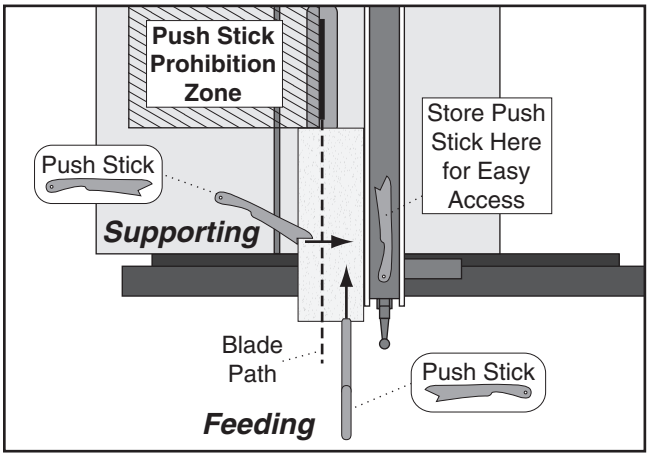


Figure 138. Using push sticks to rip narrow stock.

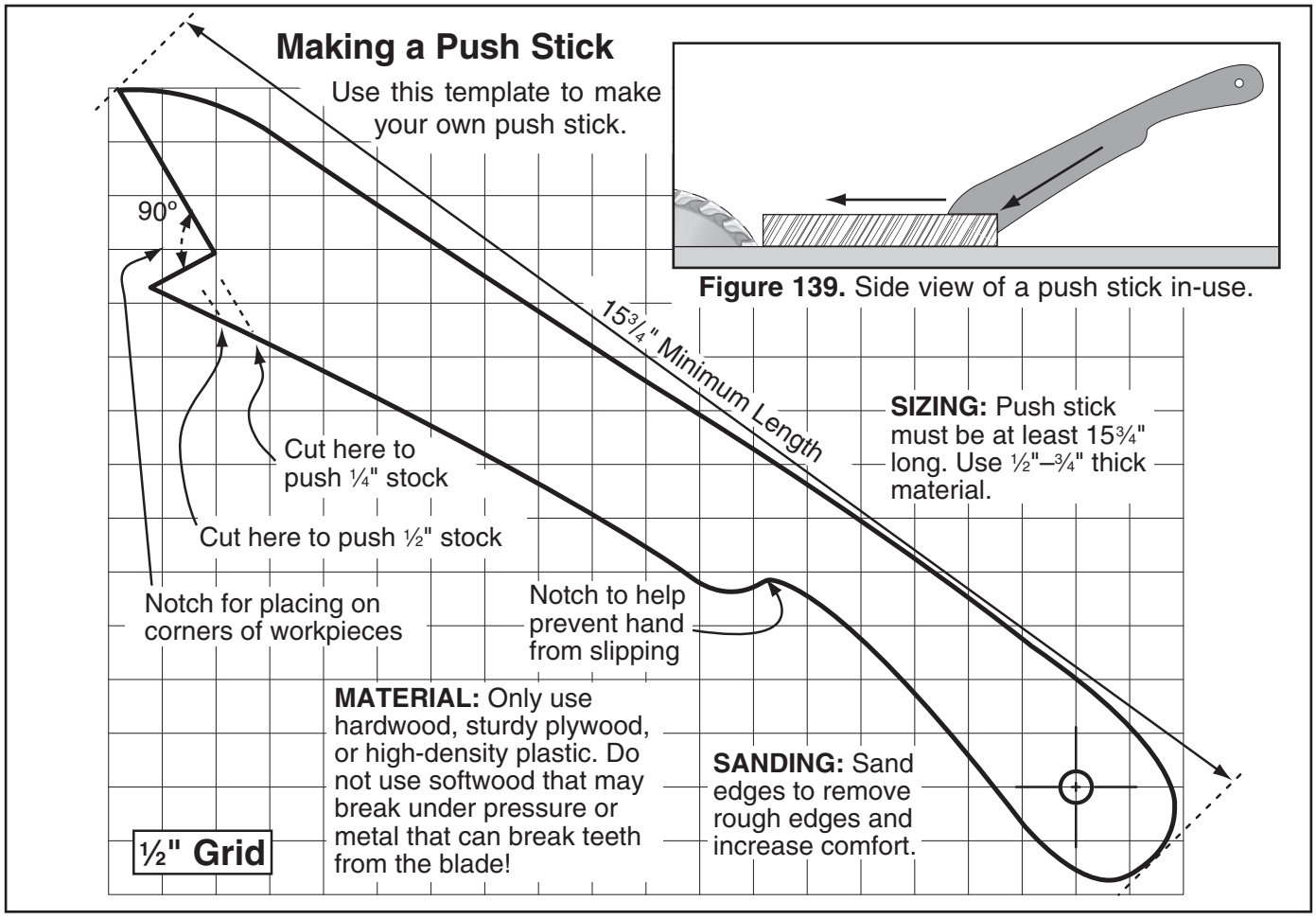

Making a Push Stick
Use this template to make your own push stick.
90°
15¾" Minimum Length
Cut here to push ¼" stock
Cut here to push ½" stock
Notch for placing on corners of workpieces
Notch to help prevent hand from slipping
SIZING: Push stick must be at least 15¾" long. Use ½"–¾" thick material.
MATERIAL: Only use hardwood, sturdy plywood, or high-density plastic. Do not use softwood that may break under pressure or metal that can break teeth from the blade!
SANDING: Sand edges to remove rough edges and increase comfort.
½" Grid

Figure 139. Side view of a push stick in-use.

Figure 140. Template for a basic shop-made push stick (not shown at actual size).

Push Blocks

When used correctly, a push block reduces the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push block often takes the damage that would have otherwise happened to hands or fingers.

Using a Push Block

A push block can be used in place of or in addition to a push stick for feeding workpieces into the blade. Due to their design, push blocks allow the operator to apply firm downward pressure on the workpiece that could not otherwise be achieved with a push stick.

The push block design on this page can be used in two different ways (see inset **Figure** below). Typically, the bottom of the push block is used until the end of the workpiece reaches the blade.

The notched end of the push block is then used to push the workpiece the rest of the way through the cut, keeping the operator's hands at a safe distance from the blade. A push stick is often used at the same time in the other hand to support the workpiece during the cut (see "Using a Push Stick" on previous page).

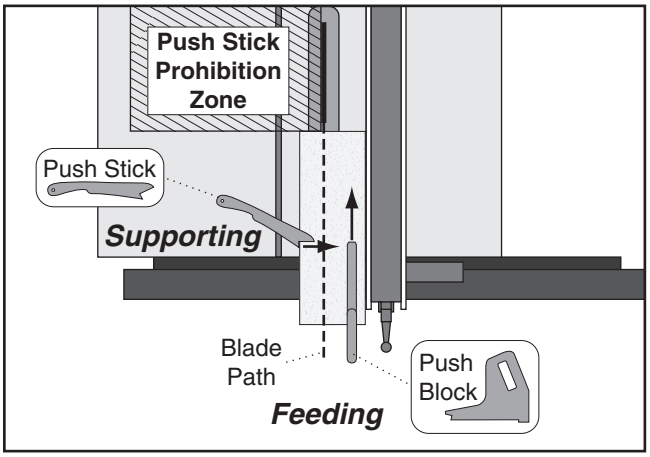


Figure 142. Using a push block and push stick to make a rip cut.

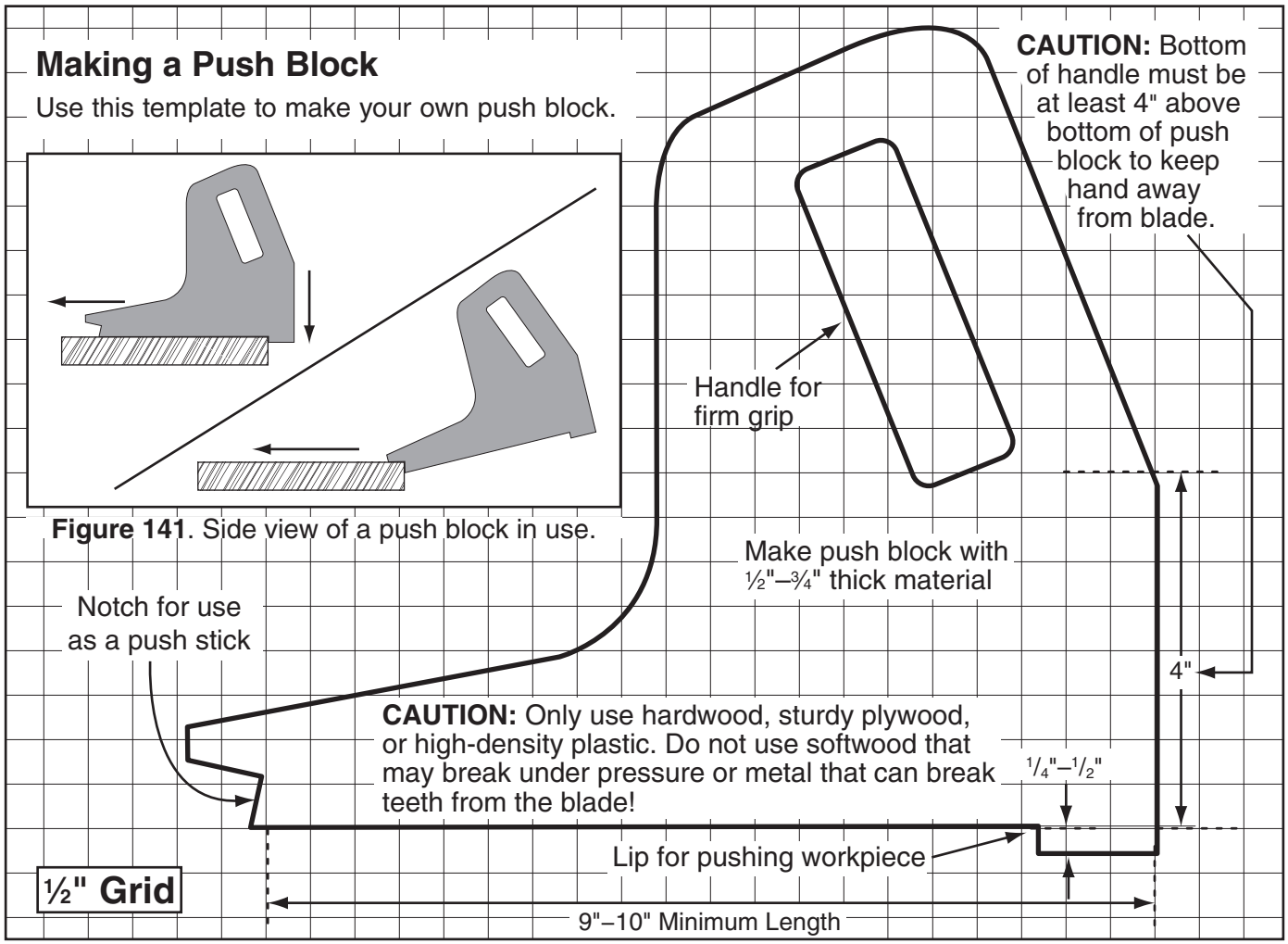

Making a Push Block
Use this template to make your own push block.
CAUTION: Bottom of handle must be at least 4" above bottom of push block to keep hand away from blade.
Handle for firm grip
Make push block with ½"–¾" thick material
Notch for use as a push stick
4"
CAUTION: Only use hardwood, sturdy plywood, or high-density plastic. Do not use softwood that may break under pressure or metal that can break teeth from the blade!
¼"–½"
Lip for pushing workpiece
½" Grid
9"–10" Minimum Length

Figure 141. Side view of a push block in use.

Figure 143. Template for a shop-made push block (shown at 50% of full size).

Narrow-Rip Auxiliary Fence & Push Block

There are designs for hundreds of specialty jigs that can be found in books, trade magazines, and the internet. These types of jigs can greatly improve the safety and consistency of cuts. They are particularly useful during production runs when dozens or hundreds of the same type of cut need to be made.

The narrow-rip auxiliary fence and push block system shown in this section is an example of a specialty jig that can be made to increase the safety of very narrow rip cuts.

Material Needed for Narrow Rip Auxiliary Fence & Push Block

Hardwood ¾" x 3" x Length of Fence 1
Plywood ¾" x 5¼" x Length of Fence 1
Wood Screws #8 x 1½" 8

Material Needed for Push Block

Hardwood or Plywood ¾" x 15" x 5⅝" 1
Hardwood or Plywood ¾" x 10" x 5"–9" 1
Cyanoacrylate Wood Glue .....Varies
Wood Screws #8 x 1½" .....As Needed

Making a Narrow-Rip Push Block for an Auxiliary Fence

1. Cut piece of ¾" thick plywood 5¼" wide and as long as your table saw rip fence; cut piece of ¾" thick hardwood 3" wide and as long as your table saw rip fence (see **Figure 144**).

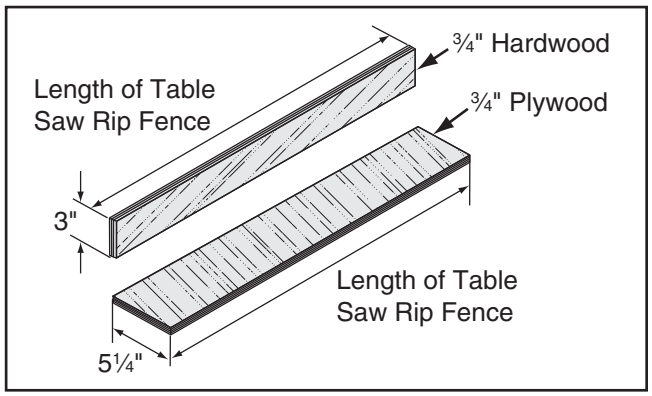


Figure 144. Auxiliary fence dimensions.

Note: *We recommend cutting the hardwood board oversize, then jointing and planing it to the correct size to make sure the board is square and flat. Only use furniture-grade plywood or kiln-dried hardwood to prevent warping.*

2. Pre-drill and countersink eight pilot holes ⅜" in from edge of 5¼" wide board, then secure boards together with eight #8 x 1½" wood screws, as shown in **Figure 145**.

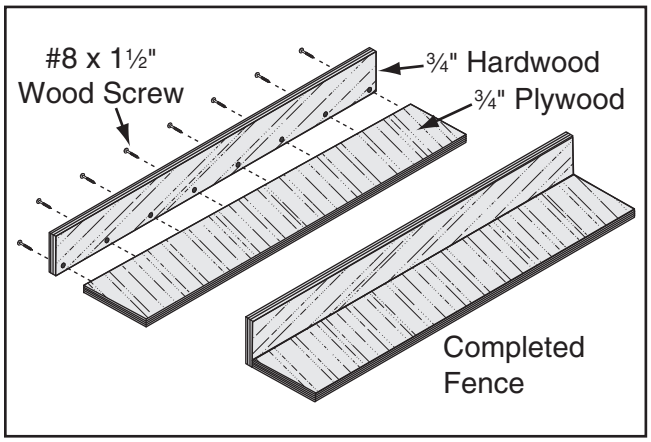


Figure 145. Location of pilot holes.

3. Using ¾" material you used in previous steps, cut out pieces for push block per the dimensions shown in **Figure 146**; for handle, cut a piece 10" long by 5"–9" high and shape it as desired to fit your hand.

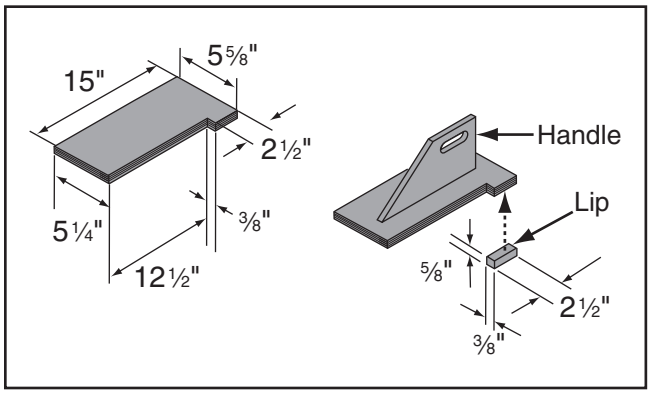


Figure 146. Push block dimensions and construction.

4. Attach handle to base with #8 x 1½" wood screws, and attach lip to base with cyanoacrylate-type wood glue.

Using the Auxiliary Fence & Push Block

1. Place auxiliary fence on table and clamp it to fence at both ends, then adjust distance between auxiliary fence and blade—this determines how wide workpiece will be ripped (see **Figure 147**).

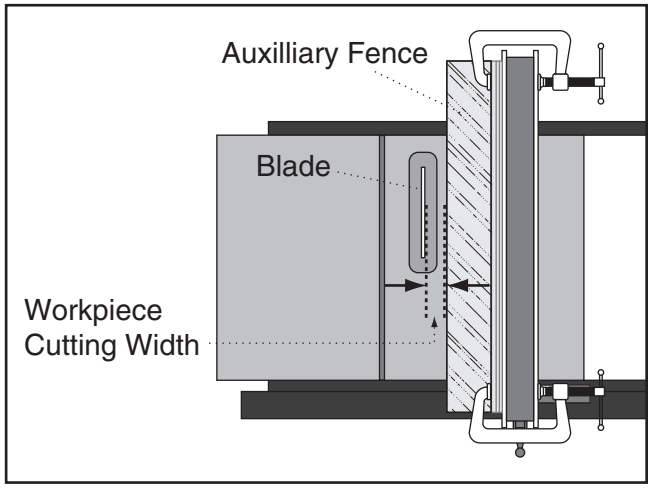


Figure 147. Adjusting ripping distance between blade and auxiliary fence.

2. Postiion blade guard according to height of workpiece.

3. Place workpiece 1" behind blade and evenly against table and auxiliary fence.

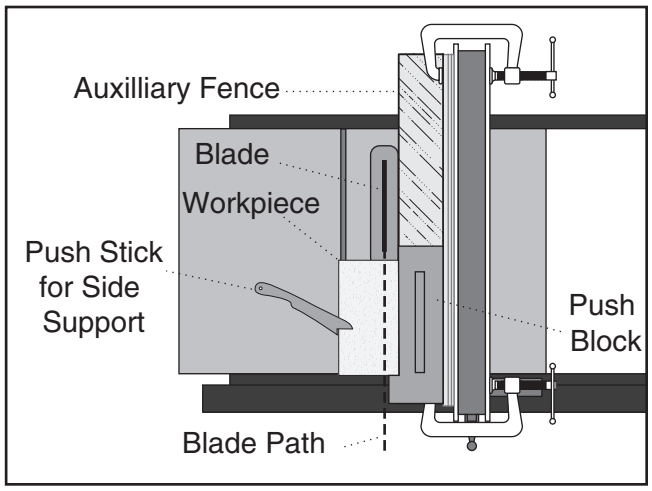


Figure 148. Push block in position to push workpiece through blade.

4. Turn saw ***ON***, then begin ripping workpiece using a push stick for side support.

5. As workpiece nears end of cut, place push block on auxiliary fence with lip directly behind workpiece, then release push stick just before blade.

6. Guide workpiece rest of way through cut with push block, as shown in **Figure 149**.

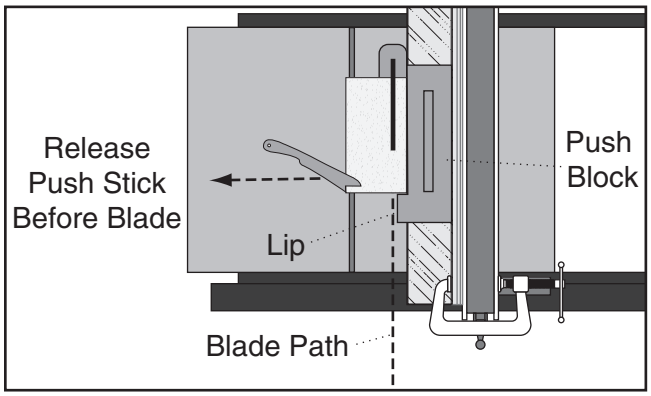


Figure 149. Ripping with push block.

⚠WARNING

Turn *OFF* the saw and allow blade to come to a complete stop before removing cut-off piece. Failure to follow this warning could result in serious personal injury.

SECTION 6: AFTERMARKET ACCESSORIES FROM GRIZZLY

⚠WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

H3388—14" Carbide-Tipped Saw Blade, 80T
H3389—14" Carbide-Tipped Saw Blade, 100T
These blades are designed especially for sliding table saws and manufactured for heavy-duty use.

Figure 150. 14" carbide tipped saw blade.

H4935—Scoring Blade Replacement
Two-piece 4¾" x 22mm 12T replacement scoring blade with shim blade for Model G0772.

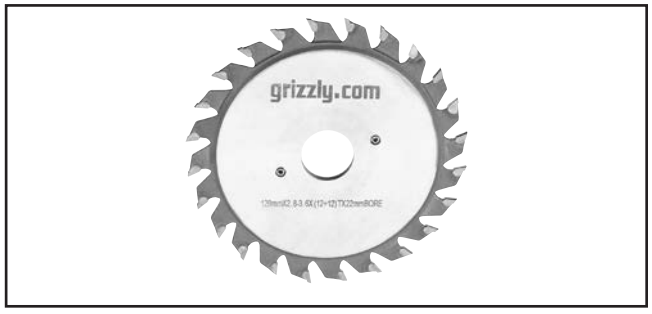


Figure 151. Model H4935 Replacement Scoring Blade.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 Oz. Spray
G2871—Boeshield® T-9 12 Oz. Spray
G2870—Boeshield® T-9 4 Oz. Spray
H3788—G96® Gun Treatment 12 Oz. Spray
H3789—G96® Gun Treatment 4.5 Oz. Spray

Figure 152. Recommended products for protecting unpainted cast iron/steel parts on machinery.

T23964—Armor Plate with Moly-D Multi-Purpose Grease, 14.5 oz. (NLGI#2 Equivalent)
Armor Plate with Moly-D is a rich green moly grease that provides excellent stability and unsurpassed performance under a wide range of temperatures and operating conditions. Armor Plate grease is entirely unique due to the fact that the moly in it is solubilized, which provides superior performance to other greases containing the black solid form of molybdenum disulfide.

Figure 153. T23964 Armor Plate with Moly-D Multi-Purpose Grease.

order online at www.grizzly.com or call 1-800-523-4777

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20451—"Kirova" Clear Safety Glasses
T20452—"Kirova" Anti-Reflective S. Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5

Figure 154. Eye protection assortment.

W1732—Adjustable Roller Stand
Specifications:
- Roller size: 19½" long x 2" dia., 9 each
- Minimum stand length: 19½"
- Maximum stand length: 54"
- Minimum stand height: 24½"
- Maximum stand height: 38"
- Casters: Polyurethane, 4¼" dia., locking
- Legs: Independently adjustable

Multiple stands can be connected for unlimited rolling capacity

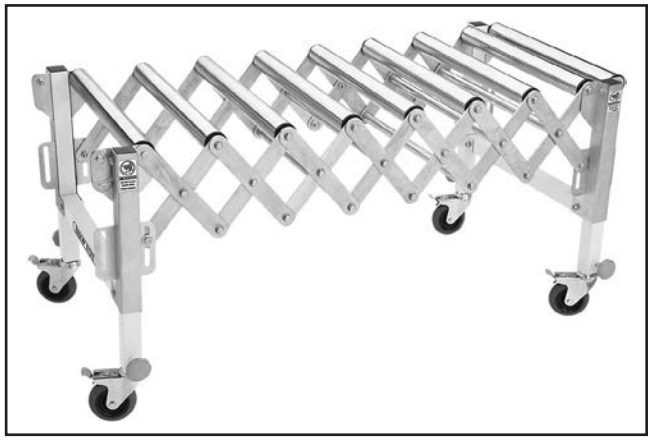


Figure 155. W1732 Adjustable Roller Stand.

G1028Z2—1½ HP Dust Collector
Specifications:
- Motor: 1½ HP, 120V/240V, prewired 120V, single-phase
- Air suction capacity: 1300 CFM
- Static Pressure: 9"
- Inlet: 6" diameter with two 4" "Y" openings
- Impeller: 12¾" Cast aluminum
- Bag capacity: 5.7 Cubic feet
- Portable base size: 21½" x 33½"
- Bag Size: 19½" x 33"
- Height with bags inflated: 78"
- CSA Certified

Figure 156. G1028Z2 Dust Collector.

D4218—Black Flexible Hose 5" x 10'
D4212—Black Flexible Hose 2½" x 10'
W1318—Wire Hose Clamp 5"
W1314—Wire Hose Clamp 2½"
W1008—Plastic Blast Gate 5"
We've hand picked a selection of commonly used dust collection components for the Model G0772.

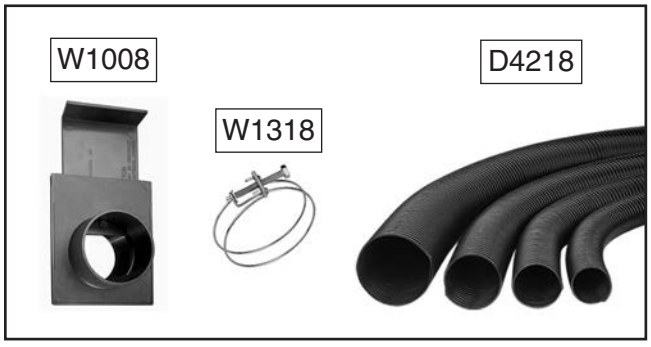


Figure 157. Recommended dust collection accessories.

H6290—Scissor Lift Table, 330 lb. Capacity
This rugged and affordable lifting table allows you to lift stacks of sheet goods right up to the saw table with just the power of your leg and the mechanical advantage of a scissor lift. The table features a hand lever release, fold-down handle, two locking swivel casters, and two fixed casters.

Figure 158. H6290 Scissor Lift Table.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 159. Half-mask respirator with disposable cartridge filters.

H8029—5-Piece Safety Kit
This kit has four essential jigs. Includes two push blocks, push stick, featherboard, and combination saw and router gauge. Featherboard fits ⅜" x ¾" miter slots. Made of high-visibility yellow plastic.

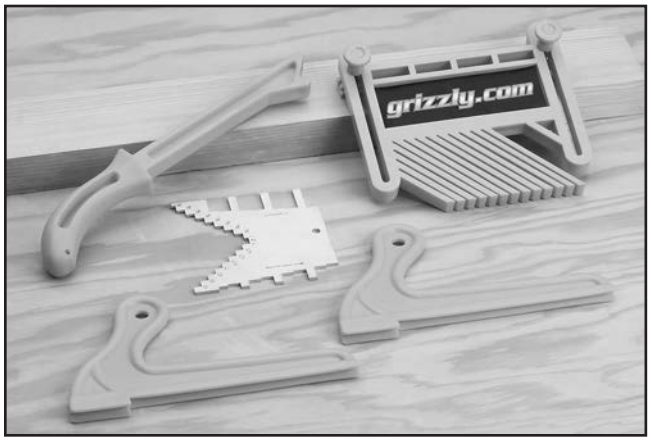
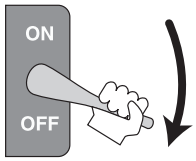


Figure 160. H8029 5-Piece Safety Kit.

G0572—Hanging Air Filter with Remote
This Hanging Air Filter has a convenient remote control and features a three-speed motor, automatic shutoff timer, 1-micron secondary filter, and 5-micron primary filter. Air flow is 556, 702, and 1044 CFM. Overall size is 26" long x 19¼" wide x 15" high. Approximate shipping weight is 58 lbs.

Figure 161. G0572 Hanging Air Filter with Remote.

SECTION 7: MAINTENANCE



⚠WARNING
To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:
- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance:
- Clean sliding table surface and grooves.
- Clean and protect cast iron table.
- Clean rip fence and slide ways.

Monthly Maintenance:
- Clean/vacuum dust buildup from inside cabinet and off motors.
- Check/replace belts for proper tension, damage or wear (**Page 79**).

Every 6–12 Months:
- Lubricate arbor mount (**Page 76**).
- Lubricate scoring motor leadscrew (**Page 76**).
- Lubricate cross slide ball oiler (**Page 76**).

Cleaning & Protecting

Cleaning the saw is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on the bare metal surface. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Figure 162**).

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 Oz. Spray
G2871—Boeshield® T-9 12 Oz. Spray
G2870—Boeshield® T-9 4 Oz. Spray
H3788—G96® Gun Treatment 12 Oz. Spray
H3789—G96® Gun Treatment 4.5 Oz. Spray

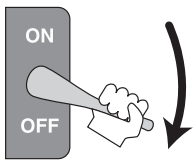
Figure 162. Recommended products for protecting unpainted cast iron/steel parts on machinery.

Lubrication

An essential part of lubrication is cleaning the components before lubricating them. This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more lubrication to built-up grime will not result in smooth-moving parts. Clean the components in this section with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

All bearings and linear actuators are sealed and permanently lubricated. Leave them alone until they need to be replaced.

Refer to **Page 72** for NLGI#2 grease (T23964) available from Grizzly.



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Arbor Mount

Lubrication Type ...T23964 or NLGI#2 Equivalent
Amount ..... 1–2 Pumps
Lubrication Frequency .....6–12 Months

The blades and motors rotate on an arbor mount that require adding lubricant to the grease fittings shown in **Figure 163**.

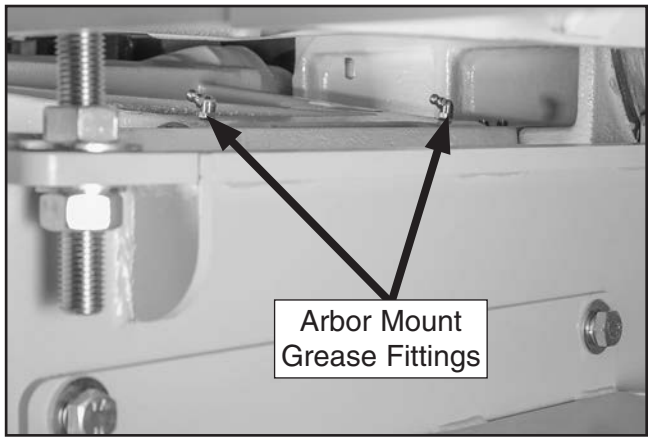


Figure 163. Two grease fittings located on top of arbor mount.

Scoring Motor Leadscrews

Lubrication Type ...T23964 or NLGI#2 Equivalent
Amount ..... 1–2 Pumps
Lubrication Frequency .....6–12 Months

Add lubrication to the leadscrews shown in **Figure 164**.

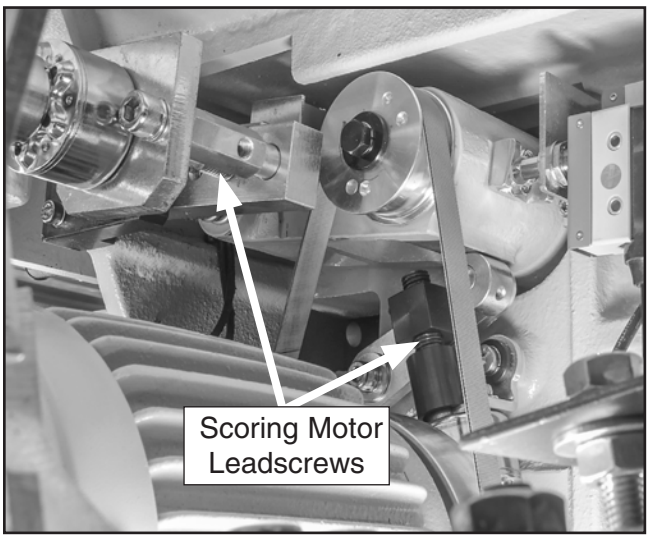


Figure 164. Location of scoring motor leadscrews.

Cross Slide Ball Oiler

Lubrication Type ....T23963 or ISO 32 Equivalent
Amount ..... 1–2 Pumps
Lubrication Frequency .....6–12 Months

Add lubrication to cross slide ball oilers (1 of 2) shown in **Figure 165**.

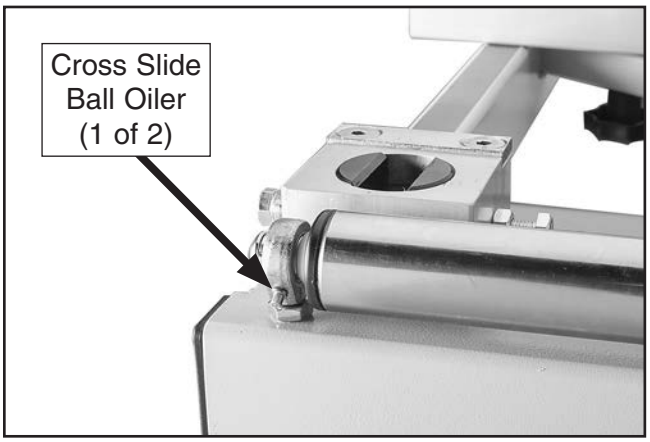
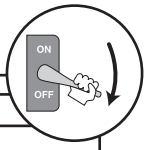


Figure 165. Location of cross slide ball oiler.

SECTION 8: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting

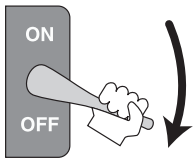


Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Emergency stop button depressed/at fault. 2. Master power switch turned ***OFF*** or is at fault. 3. Limit switch engaged or at fault. 4. Incorrect power supply voltage or circuit size. 5. Blown fuse inside electrical panel. 6. Power supply circuit breaker tripped or fuse blown. 7. Motor wires connected incorrectly. 8. Wiring open/has high resistance. 9. ON/OFF switch at fault. 10. Start capacitor at fault. 11. Thermal overload relay has tripped. 12. Magnetic switch contactor not energized/ has poor contacts. 13. Start delay module at fault. 14. Motor at fault.	1. Rotate button head to reset; replace. 2. Turn master power switch ***ON***; replace. 3. Re-adjust component to unengage limit switch. 4. Ensure correct power supply voltage and circuit size. 5. Replace fuse/ensure no shorts. 6. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 7. Correct motor wiring connections. 8. Check/fix broken, disconnected, or corroded wires. 9. Replace switch. 10. Test/replace. 11. Reset; adjust trip load dial if necessary; replace. 12. Test all legs for power/replace. 13. Adjust to correct delay/replace. 14. Test/repair/replace.
Blades rotate in the opposite direction as they should.	1. Two of the incoming power wires are reversed.	1. Reverse R & T incoming power connections in junction box (**Page 39**).
Machine stalls or is underpowered.	1. Workpiece material not suitable for machine. 2. Feed rate/cutting speed too fast. 3. Workpiece crooked; fence loose or misadjusted. 4. Belt(s) slipping. Oil/grease on belt(s). 5. Motor wired incorrectly. 6. Machine undersized for task. 7. Motor overheated. 8. Dull blades. 9. Run capacitor at fault. 10. Pulley slipping on shaft. 11. Magnetic switch contactor not energized/ has poor contacts.	1. Only cut wood/ensure moisture is below 20%. 2. Decrease feed rate/cutting speed. 3. Straighten or replace workpiece/adjust fence. 4. Tension/replace belt(s); ensure pulleys are aligned. Clean belt(s). 5. Wire motor correctly. 6. Use correct, sharp blade; reduce feed rate or depth of cut. 7. Clean motor, let cool, and reduce workload. 8. Sharpen/replace blades. 9. Test/repair/replace. 10. Replace loose pulley. 11. Test all legs for power/replace.

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. Blade is at fault. 3. Worn or damaged belts. 4. Pulley is loose. 5. Motor mount loose/broken. 6. Machine is incorrectly mounted or sits unevenly. 7. Motor fan is rubbing on fan cover. 8. Arbor bearings are at fault. 9. Motor bearings are at fault.	1. Inspect/replace stripped or damaged bolts/nuts, and retighten with thread locking fluid. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Replace worn or damaged belts (**Page 79**). 4. Re-align/replace shaft, pulley, set screw, and key as required. 5. Tighten/replace. 6. Tighten/replace anchor studs in floor; relocate/shim machine. 7. Replace dented fan cover; replace loose/damaged fan. 8. Replace arbor bearings; replace arbor. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Workpiece has burned edges, binds, or kicks back.	1. Sliding table is not parallel to blade. 2. Blade is warped.	1. Make sliding table parallel to blade (**Page 82**). 2. Replace blade.
Workpiece has chip out on the bottom edge.	1. Scoring blade height is incorrect. 2. Scoring blade is not aligned with main blade. 3. Scoring blade kerf does not match the main blade.	1. Adjust height of scoring blade (**Page 52**). 2. Align scoring blade (**Page 52**). 3. Replace scoring blade set to match main blade kerf (**Page 51**).
Sliding table saw does not cut square.	1. Sliding table is not parallel to blade. 2. Crosscut fence is not perpendicular to blade.	1. Make sliding table parallel to blade (**Page 82**). 2. Adjust crosscut fence perpendicular to blade (**Page 84**).
Rip fence hits table top when sliding across table.	1. Rail is too low. 2. Rip fence roller is too low.	1. Raise front rail (**Page 83**). 2. Adjust rip fence roller (**Page 83**).
Blade does not reach 0˚, or blade does not reach 45˚.	1. Blade tilt stop bolt nuts are out of adjustment.	1. Adjust stop bolts (**Page 80**).
Rip fence scale is not accurate.	1. Rip fence scale out of calibration or not set up correctly.	1. Calibrate rip fence scale (**Page 83**).
Crosscut scale is not accurate.	1. Crosscut fence scale not calibrated.	1. Calibrate crosscut fence scale (**Page 54**).

Belt Service

Over time, belts will stretch and wear. To maintain efficient power transfer to the blades, make sure the belts are properly tensioned and in good condition. If belts show any glazing, fraying, or cracking, replace them.



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Tensioning Scoring Motor Belt

The scoring motor uses a flat belt. Proper tension of this belt is automatically maintained by a torsion spring on the motor pivot rod (see **Figure 166**).

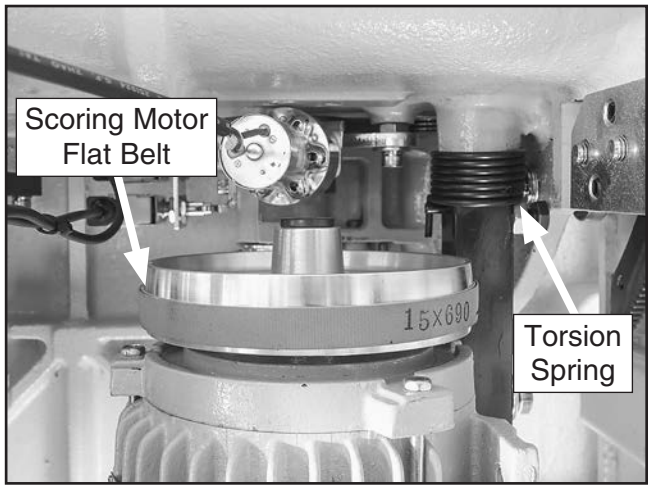


Figure 166. Scoring motor flat belt and tensioning spring.

Replacing Scoring Motor Belt

To replace the scoring motor belt, lift the scoring motor up by pulling it towards the main motor, relieving the belt tension. Chock the motor in the up position by placing a 6" long scrap piece of wood between the motor and the wall of the motor compartment, as shown in **Figure 167**, then replace the belt with a new one. Remove the chock and lower the motor to apply proper belt tension.

The scoring motor belt is a standard off-the-shelf flat belt and can be purchased from Grizzly using part #P07720538.

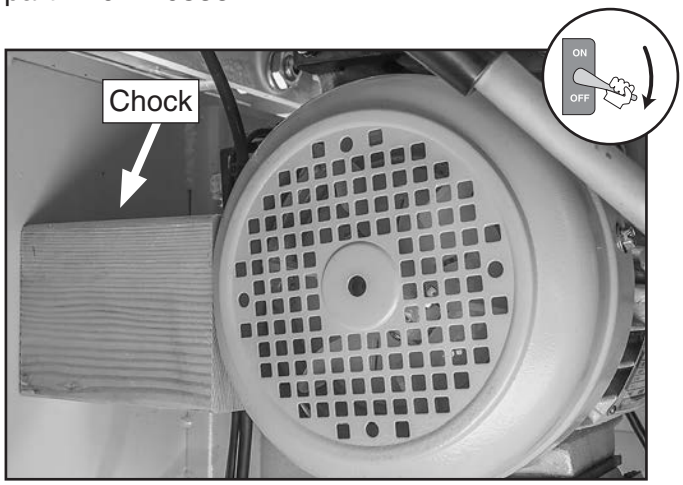


Figure 167. Chocking scoring motor to relieve belt tension during replacement.

Tensioning Main Motor Belt

Proper tension of the main motor belt is automatically maintained by a flat spring on the motor pivot rod (see **Figure 168**).

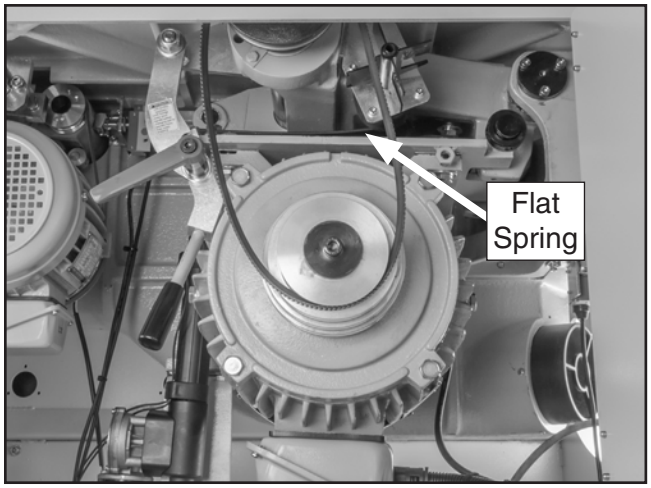
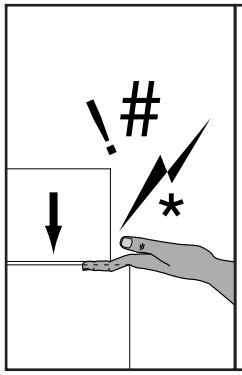


Figure 168. Location of main motor flat spring, which automatically helps maintain proper belt tension.

Replacing Main Motor Belt

A V-belt transfers power from the main motor to the main blade. It is a standard off-the-shelf belt and can be purchased from Grizzly using part #P07720351.



⚠WARNING

The main motor is extremely heavy. DO NOT attempt to lift it up with only your hands. To avoid crushing injuries, always use the following procedure when replacing the main motor belt.

Items Needed **Qty**
Gloves 1

To replace main motor belt:

1. DISCONNECT MACHINE FROM POWER!

2. Open motor cabinet door, then loosen lock handle shown in **Figure 169**.

3. Release belt tension by pulling tension release lever down until pin locks into detent notch, then tighten lock handle (See **Figure 169**).

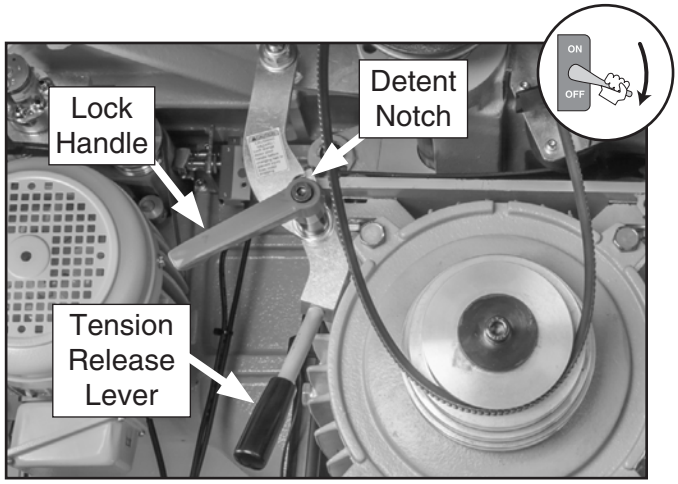


Figure 169. Main motor lock handle.

4. Carefully position belts onto desired pulleys (see **Changing Speed** on **Page 48** for additional information).

5. Loosen lock handle, then push tension release lever up to apply tension to belt through flat spring.

6. Tighten lock handle.

7. Close cabinet door before reconnecting machine to power.

Blade Tilt Calibration

The blade tilt stops are calibrated at the factory, but they can be recalibrated if they change during the life of the machine. The 0° stop positions the blade square to the table.

Tools Needed **Qty**
Wrench 17mm..... 2
Machinist's Square 90° & 45°..... 1

0° Stop Bolt

1. Move blade tilt to 0° and raise main blade as high as it will go.

2. DISCONNECT MACHINE FROM POWER!

3. Open cabinet door and identify 0° stop bolt shown in **Figure 170**.

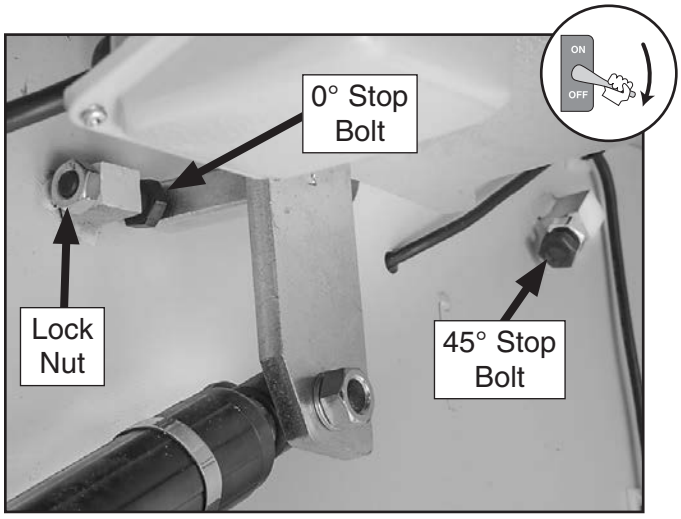


Figure 170. Blade tilt stop bolts.

4. Use machinist's square to check if main blade is square to table (see **Figure 171**).

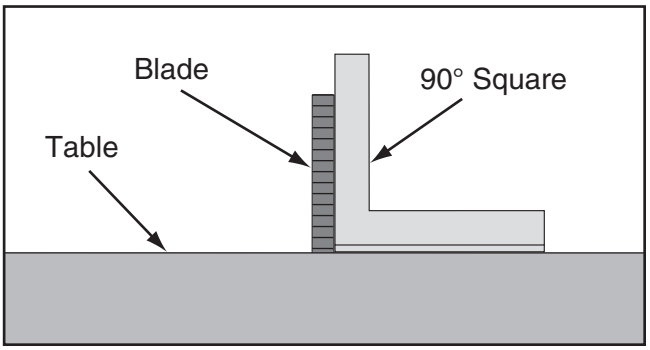


Figure 171. Machinist's square against blade and table.

—If main blade is square to table, no adjustments need to be made.

—If main blade is not square to table, proceed to **Step 5.**

5. Loosen lock nut on 0° stop bolt, then adjust stop bolt so that main blade tilt angle is square to table.

6. Tighten lock nut on stop bolt and check blade tilt. Main blade should be square to table.

—If main blade is not square to table, repeat **Steps 5–6**.

7. Connect machine to power and turn it ***ON***. Tilt display should read 0°.

—If tilt display does not read 0°, proceed to **Tilt Display Calibration.**

45° Stop Bolt

Use a similar procedure for the 45° stop bolt shown in **Figure 170** on **Page 80**, as previously instructed for the 0° stop bolt.

Tilt Display Calibration

The blade tilt display is calibrated at the factory, but it can be adjusted if blade tilt changes during the life of the machine.

To calibrate blade tilt display:

1. Move blade tilt to 0°, and raise main blade as high as it will go.

2. DISCONNECT MACHINE FROM POWER!

3. Use machinist's square to check if main blade is square to table (see **Figure 171**).

—If main blade is not square to table, perform **Blade Tilt Calibration**.

4. Connect power, and turn main power switch ON.

5. At control panel, press SET (see **Figure 81** on **Page 47**).

6. Press "0" (see **Figure 81** on **Page 47**).

7. Press and hold SET for five seconds. "0" position has now been updated in control panel.

Sliding Table Parallel Adjustment

The sliding table is adjusted parallel with the main blade at the factory, but it can be re-adjusted if necessary.

Tools Needed	Qty
Felt Tip Pen	1
90° Machinists Square	1
Precise Measuring Tool	1
Wrench or Socket 22mm	1
Wrench or Socket 17mm	1
Hex Wrench 4mm	1

To adjust sliding table parallel with main blade:

1. Raise main blade as high as it will go, and adjust tilt angle to 0°.

2. DISCONNECT MACHINE FROM POWER!

3. Mark one blade tooth with felt tip pen. This will be your reference point when taking measurements in following steps.

4. Move sliding table all the way forward. Measure distance "A" shown in **Figure 172**, which is between marked blade tooth and edge of sliding table miter slot.

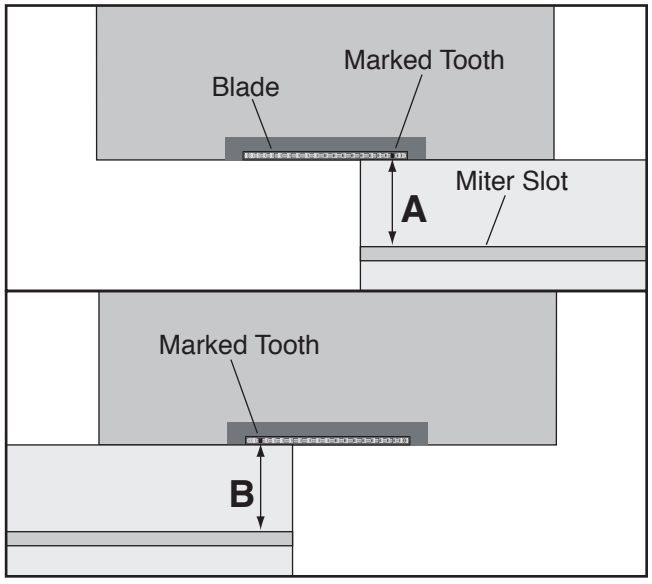


Figure 172. Measuring distance between miter slot and blade at each end of sliding table.

5. Rotate blade 180°, move sliding table all the way back, then measure distance "B" shown in **Figure 172**.

   —If "A" and "B" measurements are same or difference is 0.004" or less, no adjustments to table parallelism need be made.

   —If difference is greater than 0.004", then sliding table parallelism must be adjusted. Proceed to **Step 6**.

6. Loosen three hex bolts shown in **Figure 173** to allow sliding table base to move in next step.

7. Adjust parallelism adjustment bolts as necessary (see **Figure 173**) to make sliding table parallel with main blade.

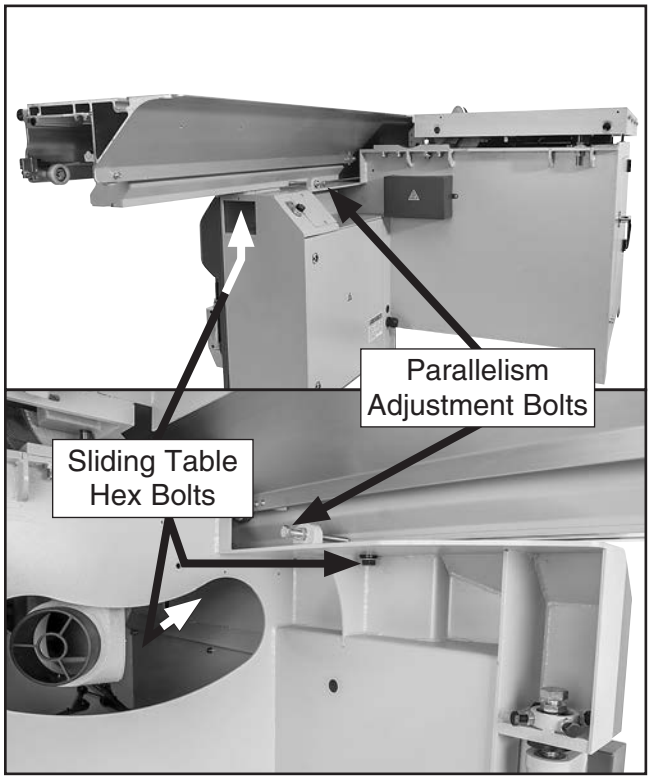


Figure 173. Location of fasteners on sliding table base and saw for making sliding table parallel with main blade.

8. Tighten hex bolts, then repeat **Steps 4–5** to verify adjustment.

   —If difference is greater than 0.004", repeat **Steps 6–8**.

Calibrating Rip Fence

There are three adjustments that affect the accuracy and operation of the rip fence: 1) Height above the table, 2) parallelism with the blade, and 3) rip fence scale position. If your cuts are not square when using the rip fence, check these adjustments. Parallelism is an important safety adjustment and the rip fence MUST be parallel with the blade to minimize the risk of kickback.

Height Above Table

The rip fence and base should ride as close to the table surface as possible without touching it and with an even gap along the length. This is accomplished by adjusting the rip fence rail and the roller at the end of the fence base.

Tools Needed **Qty**
Hex Wrench 6mm 1
Open-End Wrench 13mm 1
Open-End Wrench 7mm 1

To adjust rip fence height above table:

1. Observe gap between fence base and table along entire length.

   —If rail end of fence body is too low, loosen slide lock handle that secures rip fence rail, adjust rail until fence body gap is even, then retighten rail slide lock handle.

   —If far end of fence base is too low, slide fence base off rail. Then loosen lock nut shown in **Figure 174**, adjust base roller position, retighten lock nut, and re-install fence base on rail.

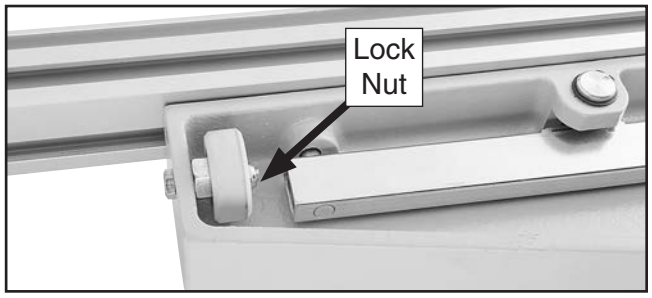


Figure 174. Rip fence base roller used for adjusting gap between fence base and table.

Parallelism To Blade

⚠CAUTION

Parallelism is an important safety adjustment. Rip fence MUST be parallel with blade to minimize risk of kickback.

Tool Needed **Qty**
Wrench 30mm 1

To adjust rip fence parallel to main blade:

1. Raise main blade all the way up and tilt to 0°.

2. DISCONNECT MACHINE FROM POWER!

3. Slide rip fence so it nearly touches main blade and measure gap at both ends of blade (see **Figure 175**).

Figure 175. Checking gap between teeth and rip fence.

   —If gap between rip fence and main blade is not even at both ends, loosen rail hex nuts and adjust one end in or out until fence is parallel with blade, then retighten hex nuts (see **Figure 176**).

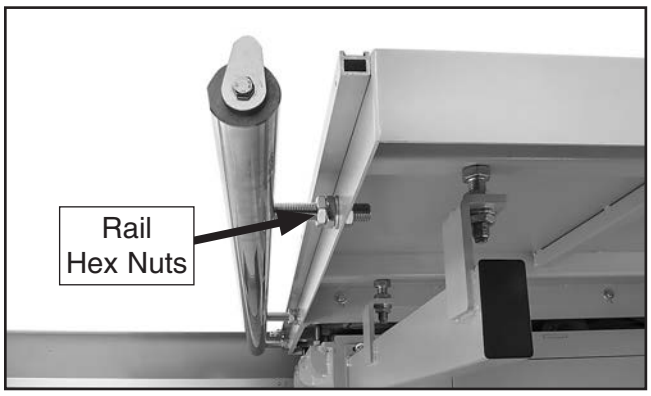


Figure 176. Rip fence rail hex nuts.

Calibrating Rip Fence Scale

Hex Wrench 5mm..... 1
Open-End Wrench 10mm..... 1

To calibrate rip fence scale:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen jam nut and remove outer rip fence stop screw shown in **Figure 177**.

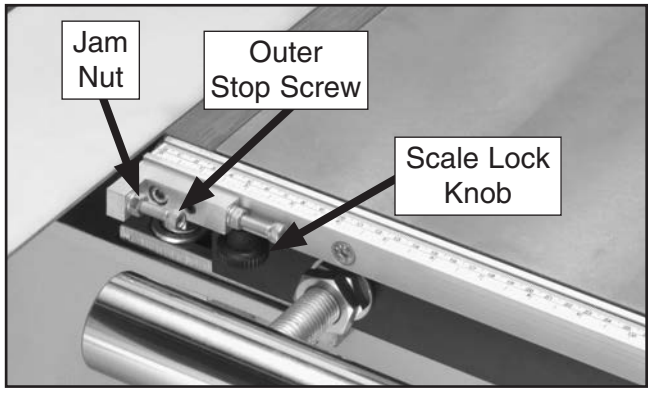


Figure 177. Rip fence outer stop screw location.

3. Make sure rip fence is parallel with main blade, then move it against blade so that it just touches teeth.

4. Loosen scale lock knob (see **Figure 177**), adjust scale so zero mark is directly under left edge of rip fence (see **Figure 178**). Retighten knob.

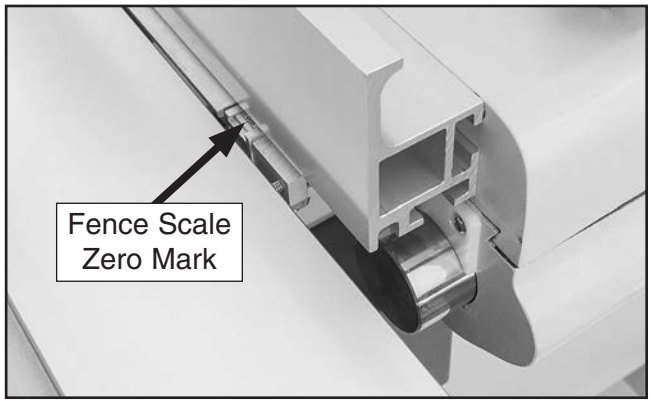


Figure 178. Rip fence zero mark.

5. Move fence away from blade, re-install outer stop screw removed in **Step 2**, and tighten jam nut.

Squaring Crosscut Fence to Blade

The crosscut fence is adjusted at the factory, but it can be re-adjusted if necessary. Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a 32" x 32" piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

Note: *Getting accurate results with this procedure is a matter of trial-and-error and patience.*

To square crosscut fence with blade:

1. Make sure sliding table is parallel with main blade (refer to **Sliding Table Parallel Adjustment** on **Page 82** for detailed instructions).

2. Make sure crosscut fence adjustment bolts and jam nuts are tight, and crosscut fence is locked into position (see **Figure 179**).

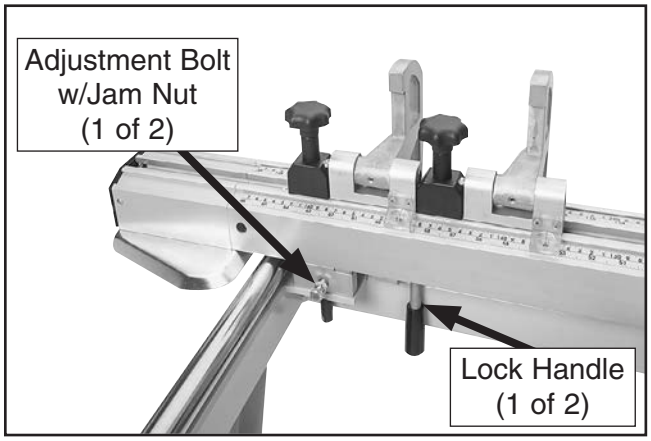


Figure 179. Crosscut fence adjustment bolts.

3. Prepare scrap test piece by cutting it to 32" x 32" square, then number all four sides 1–4 (see **Figure 180**).

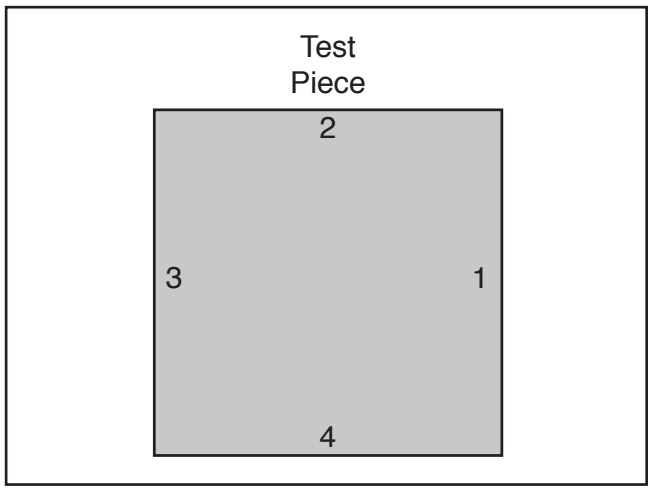


Figure 180. Fence adjustment test piece.

4. Use crosscut fence to cut ½" off of each side of test piece, then cut side 1 again (make five cuts total).

5. Measure test piece diagonally from corner-to-corner, as shown in **Figure 181**.

   —If both measurements are within 1/16", then you are finished with this procedure.

   —If both measurements are not within 1/16", then crosscut fence needs to be adjusted. Take note of difference between measurements, then proceed to **Step 6**.

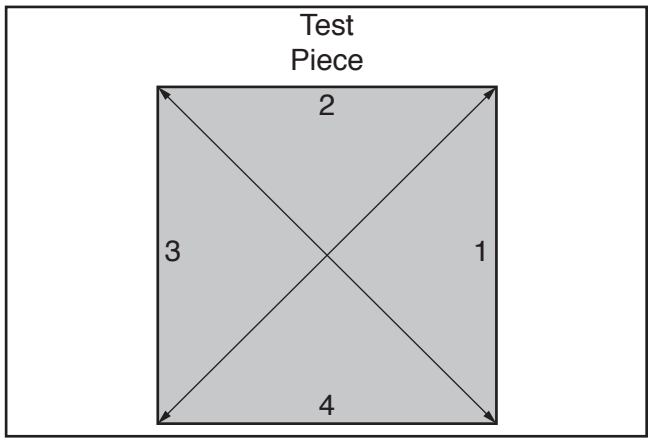


Figure 181. Diagonals to measure on test piece.

6. Loosen crosscut fence lock handles to allow fence to pivot.

7. Loosen crosscut fence adjustment bolt jam nuts (see **Figure 179** on **Page 84**).

8. Loosen one crosscut fence adjustment bolt ¼ of a turn and tighten opposite bolt until it is snug (see **Figure 179**).

   —If difference between measurements has increased after one adjustment, loosen adjustment bolt that was tightened in last cycle ½ turn and tighten opposite bolt until snug.

   —If difference between measurements has decreased but are still out of tolerance, loosen same adjustment bolt that was adjusted last cycle ¼ turn and tighten opposite bolt until snug.

9. Tighten crosscut fence adjustment bolt jam nuts.

10. Tighten crosscut fence lock handles.

11. Repeat **Steps 4–5** until both measurements are within 1/16".

SECTION 9: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

⚠WARNING
Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

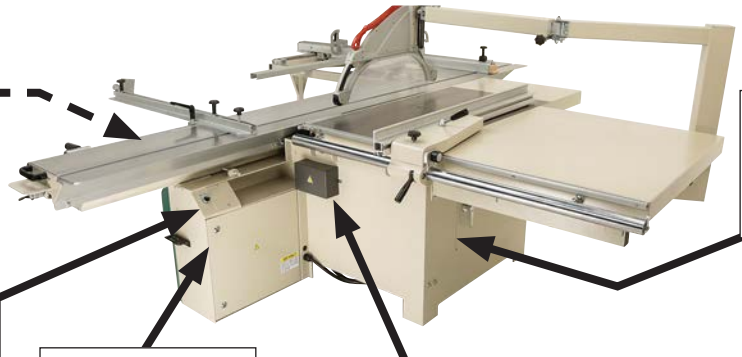
NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Electrical Overview



Control Panel

Main Blade Motors
Scoring Blade Motors
Limit Switches
Linear Actuators

Master Power Switch

Electrical Panel

Optical Encoder

Blade Angle Encoder
HONTKO
HSK-XA074 1031B

Scoring Blade Up Limit Switch
QDQ CT-7312

Scoring Blade Down Limit Switch
QDQ CT-7312

Control Panel
Page 89

Scoring Blade Elevation Motor **Page 92**

Scoring Blade Offset Motor **Page 92**

Main Blade Elevation Linear Actuator **Page 92**

Main Blade Tilt Linear Actuator **Page 92**

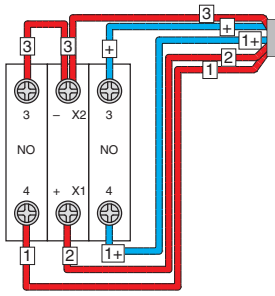
Electrical Panel **Pages 90–91**

Scoring Motor **Page 93**

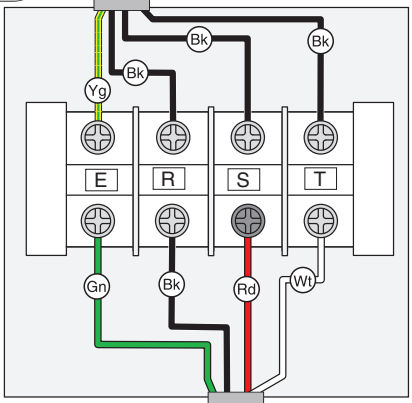
Main Motor **Page 92**

Saw Blade Door Limit Switch
QDQ CT-7312

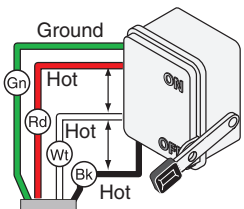
Master Power Switch
(RENY/R9C10VN/10A/600V)



Power Connection Terminal Bar



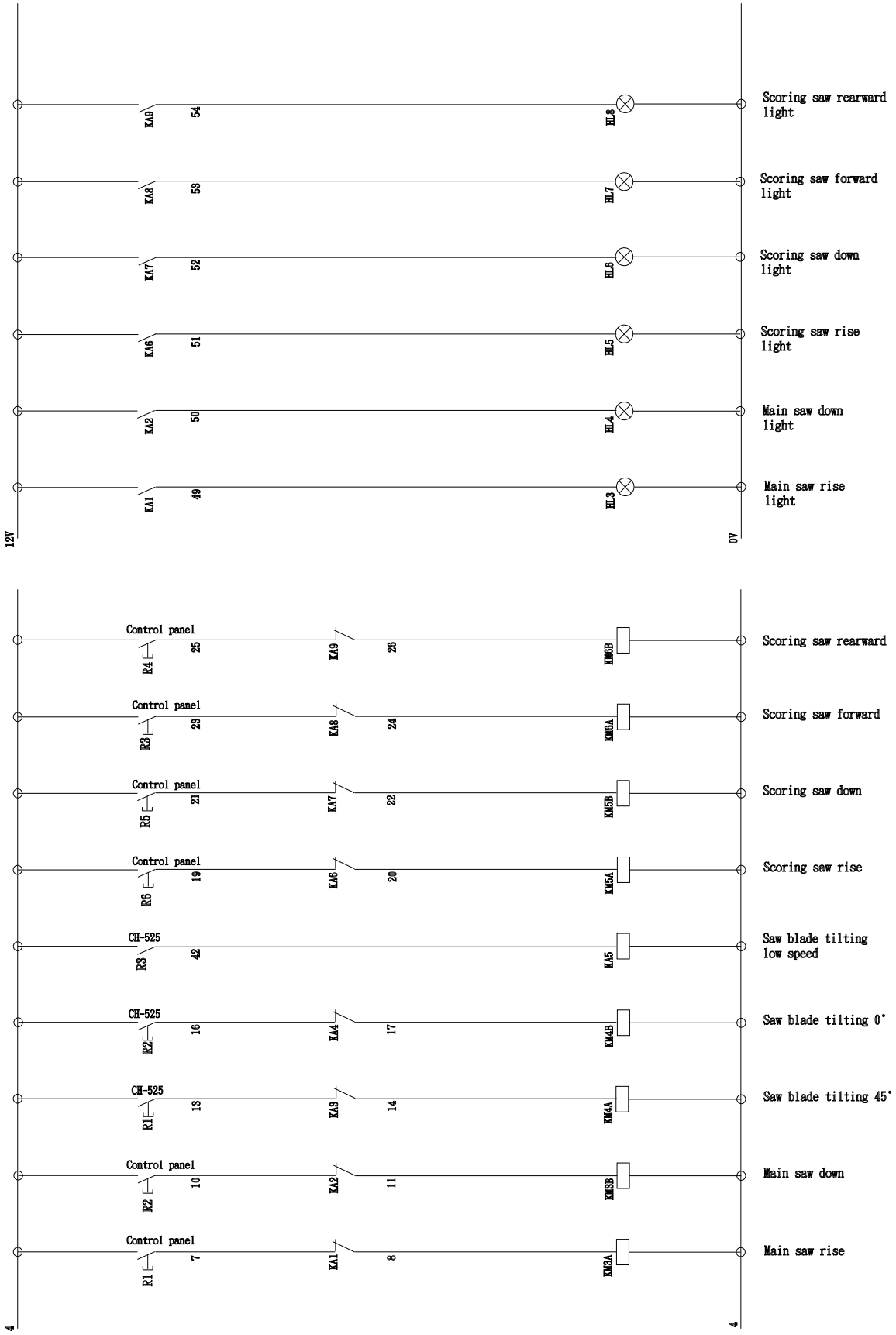
3-PHASE
220V or 440V



DISCONNECT SWITCH
(as recommended)

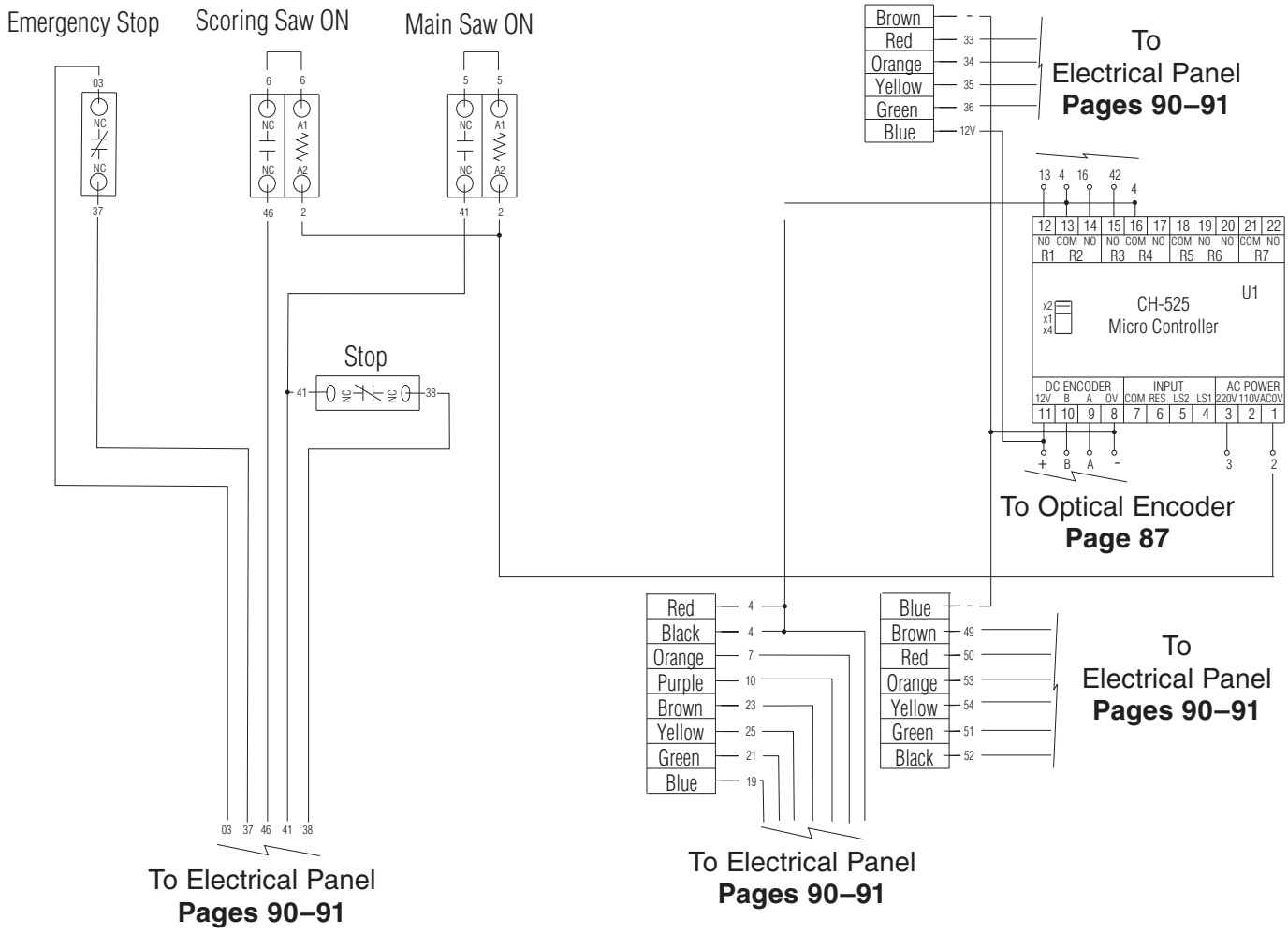
= For phase converter wild wire (if used)

Relay Logic Diagram



READ ELECTRICAL SAFETY ON PAGE 86!

Control Panel Wiring



Control Panel Wiring Photo

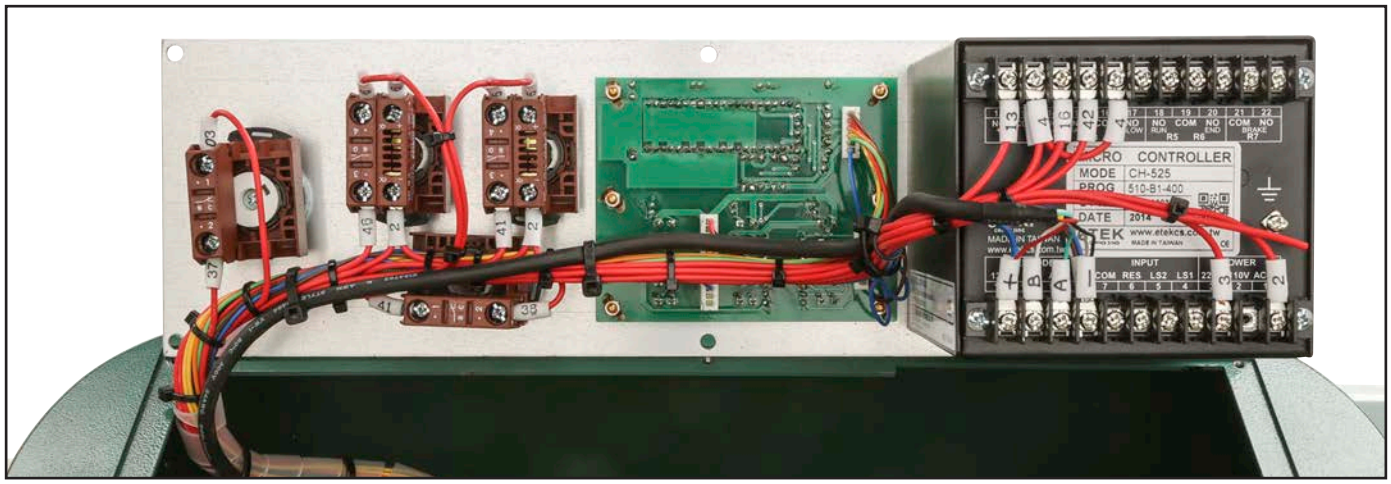
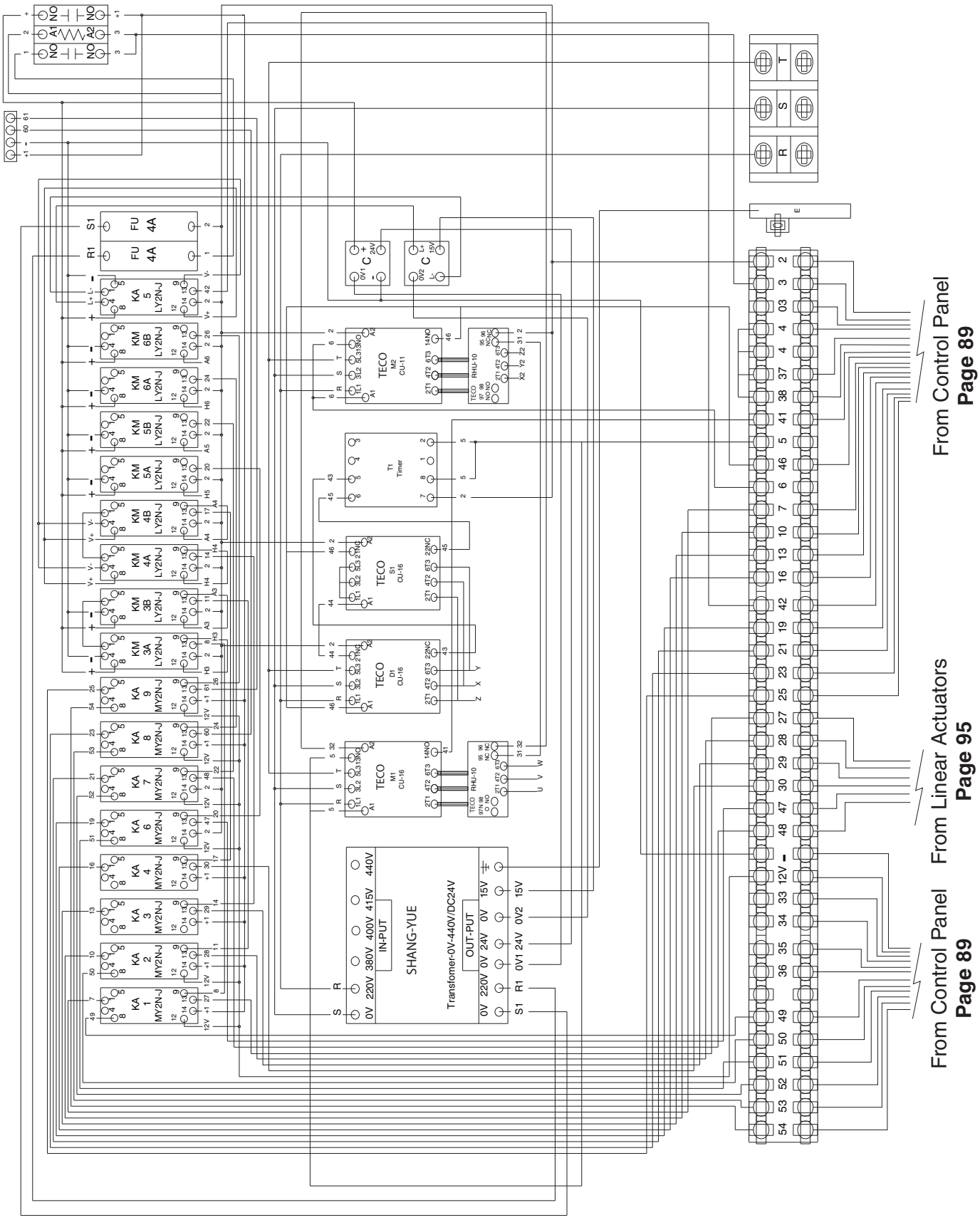


Figure 182. Control panel wiring.

220V Electrical Panel Schematic



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Electrical Panel Wiring Photo

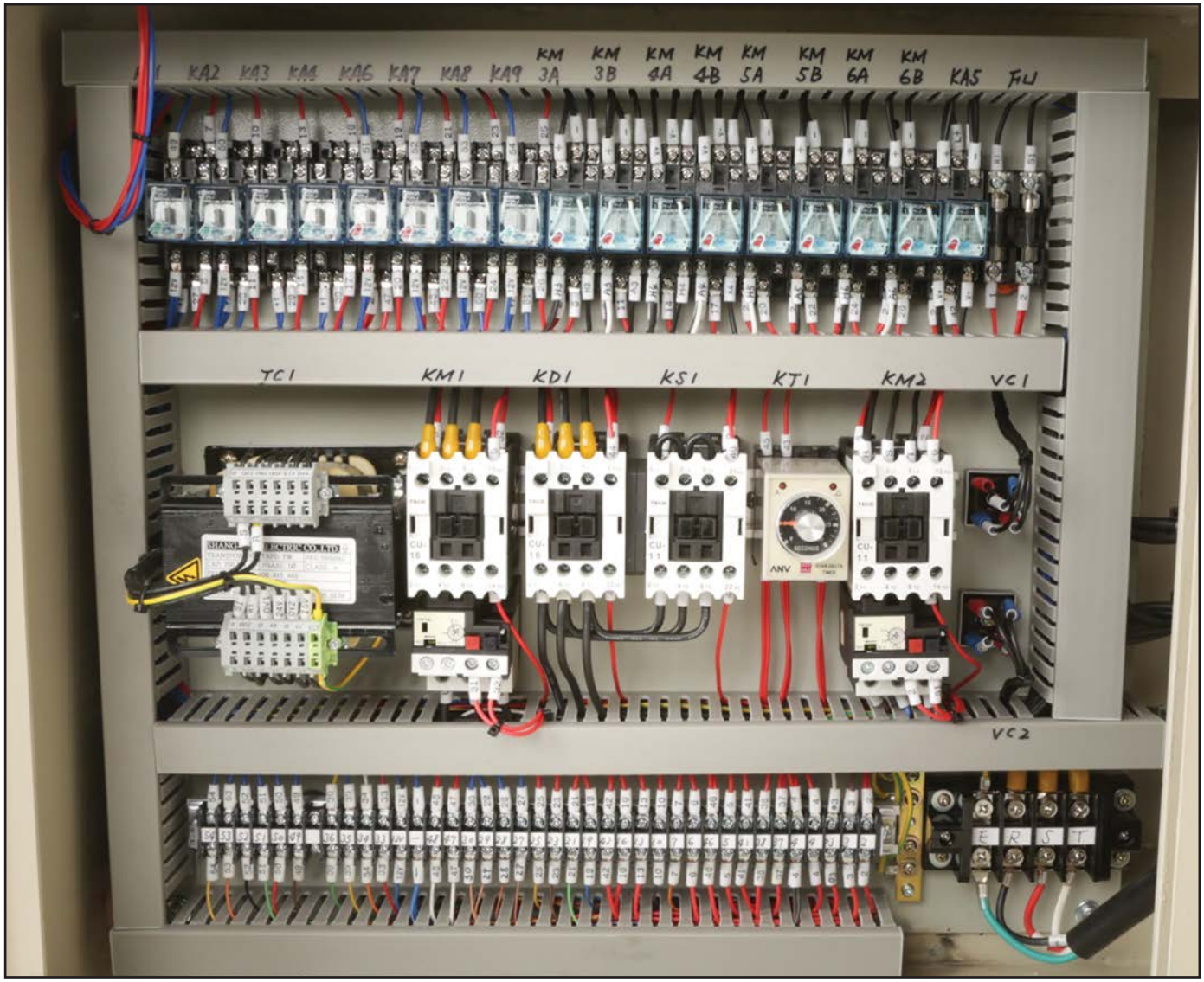
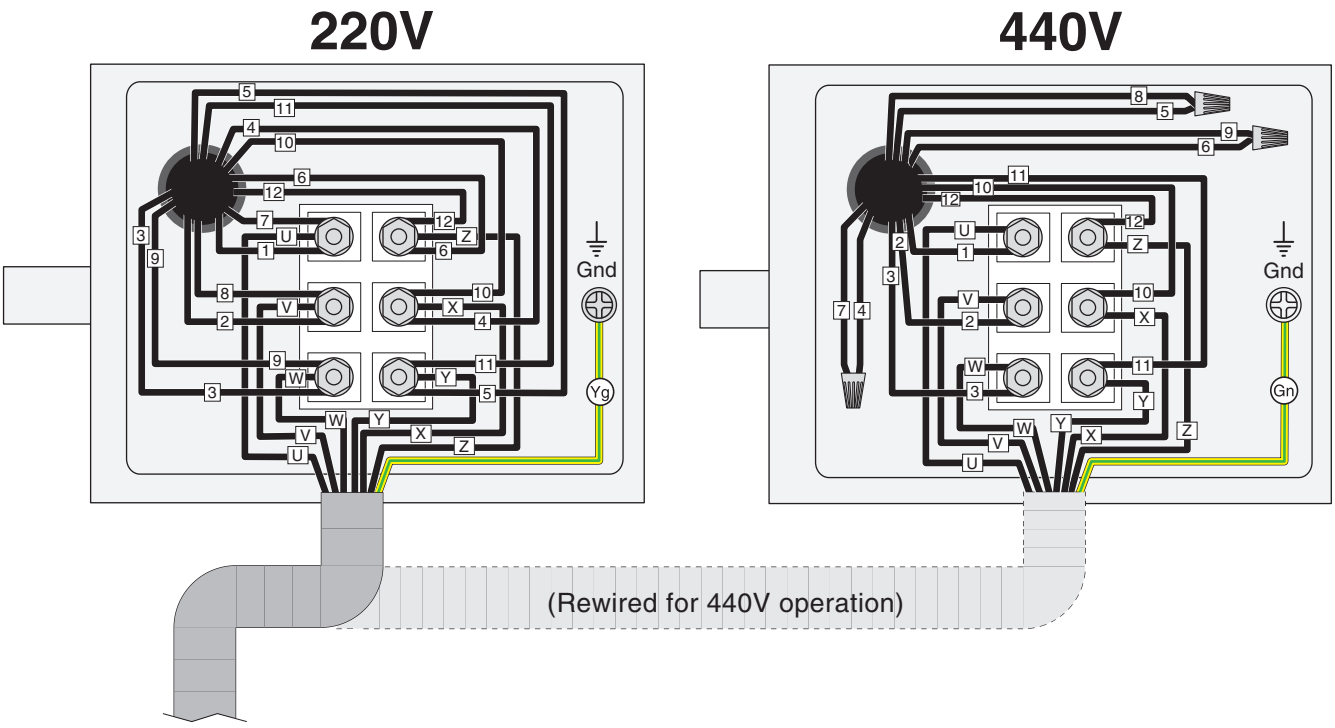


Figure 183. Electrical panel wiring.

Main Motor Wiring

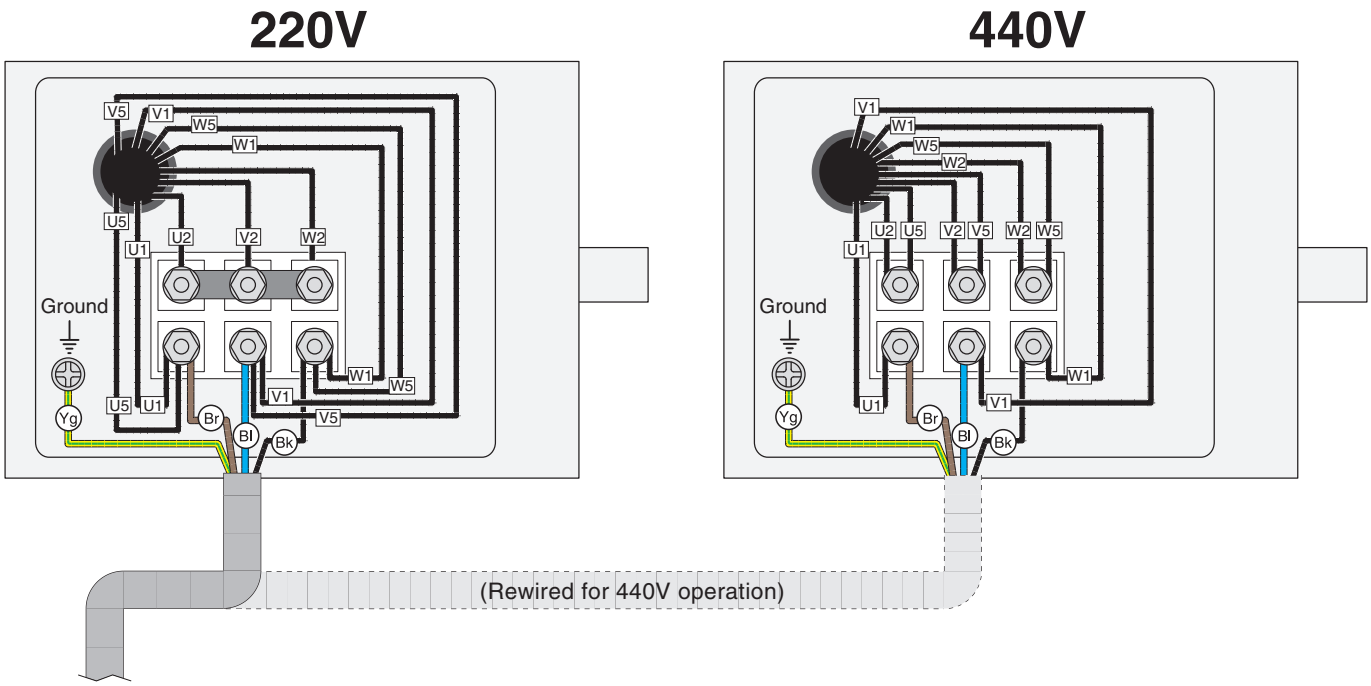


Main Motor Wiring Photo

Figure 184. Main motor wiring (shown wired for 220V).

STOP *READ ELECTRICAL SAFETY ON PAGE 86!*

Scoring Motor Wiring



To Electrical Panel
Pages 90–91

Scoring Motor Wiring Photo

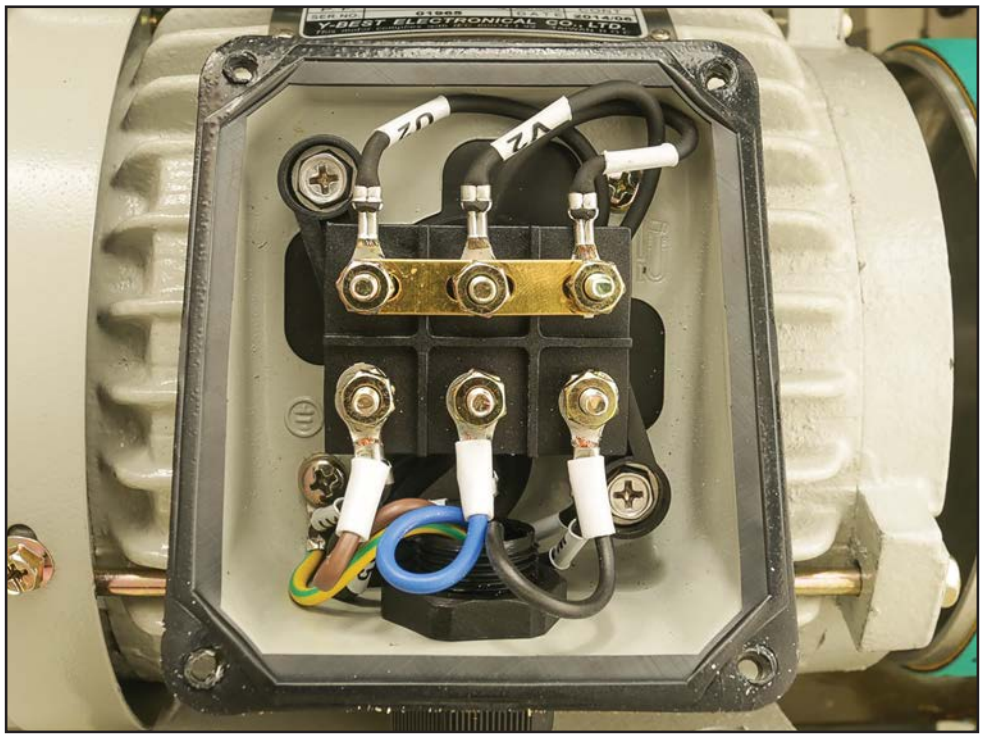


Figure 185. Scoring motor wiring (shown wired for 220V).

DC Motor Schematic

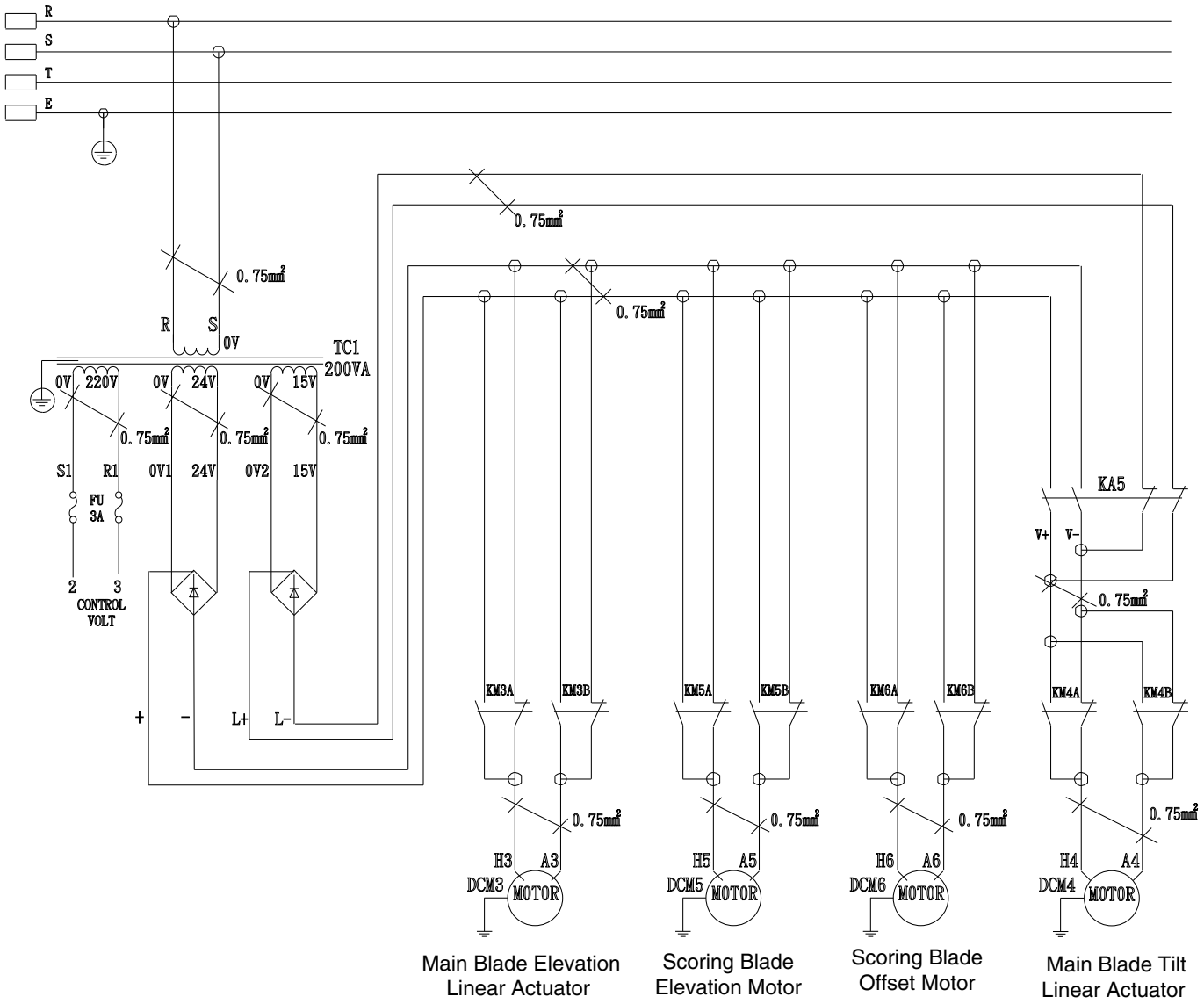


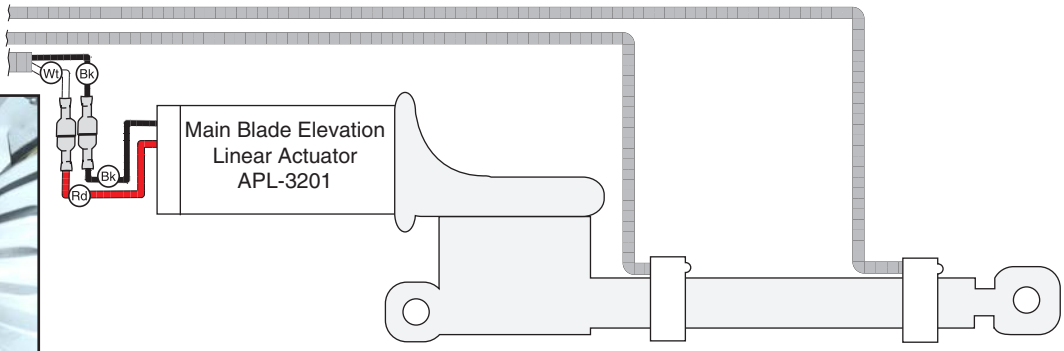
Figure 186. Scoring blade offset motor.

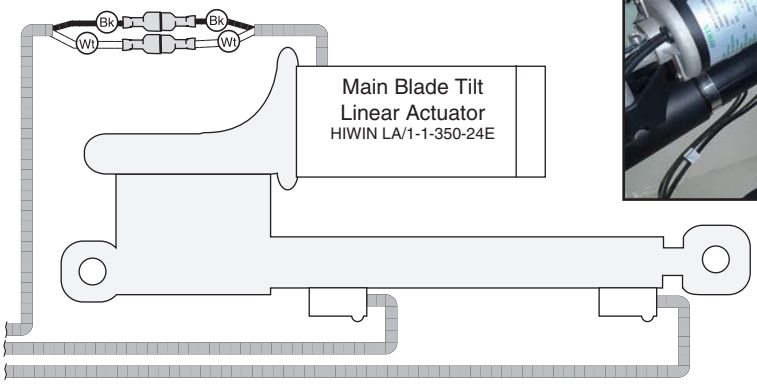
Figure 187. Scoring blade elevation motor.

STOP ***READ ELECTRICAL SAFETY ON PAGE 86!***

Linear Actuator Wiring

To Electrical Panel
Pages 90–91

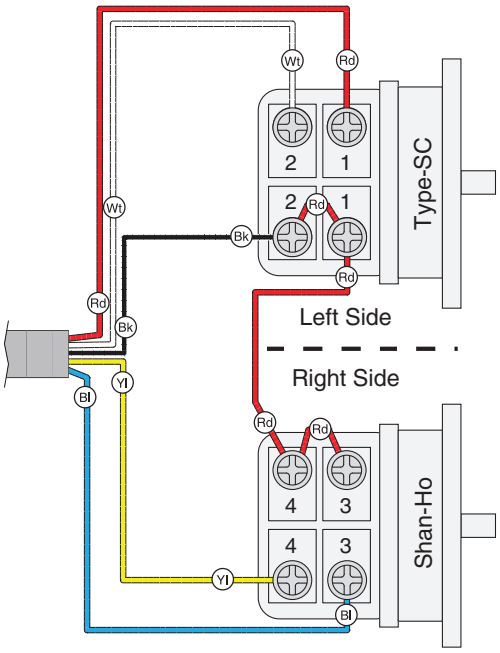




To Electrical Panel
Pages 90–91

Belt Speed Rotary Switch Wiring

To Electrical Panel
Pages 90–91

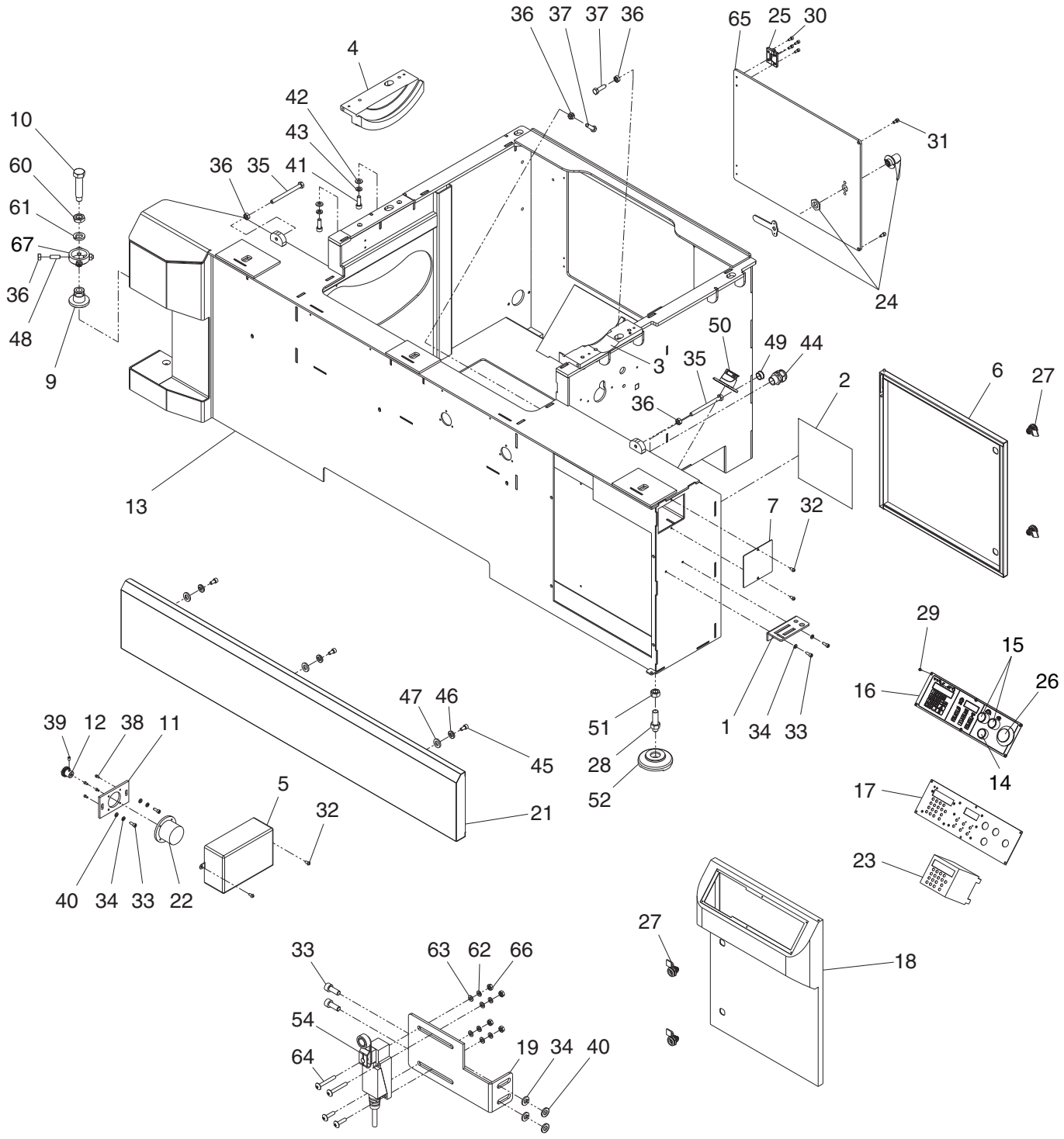


STOP ***READ ELECTRICAL SAFETY ON PAGE 86!***

SECTION 10: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call **(800) 523-4777** or visit **www.grizzly.com/parts** to check for availability.

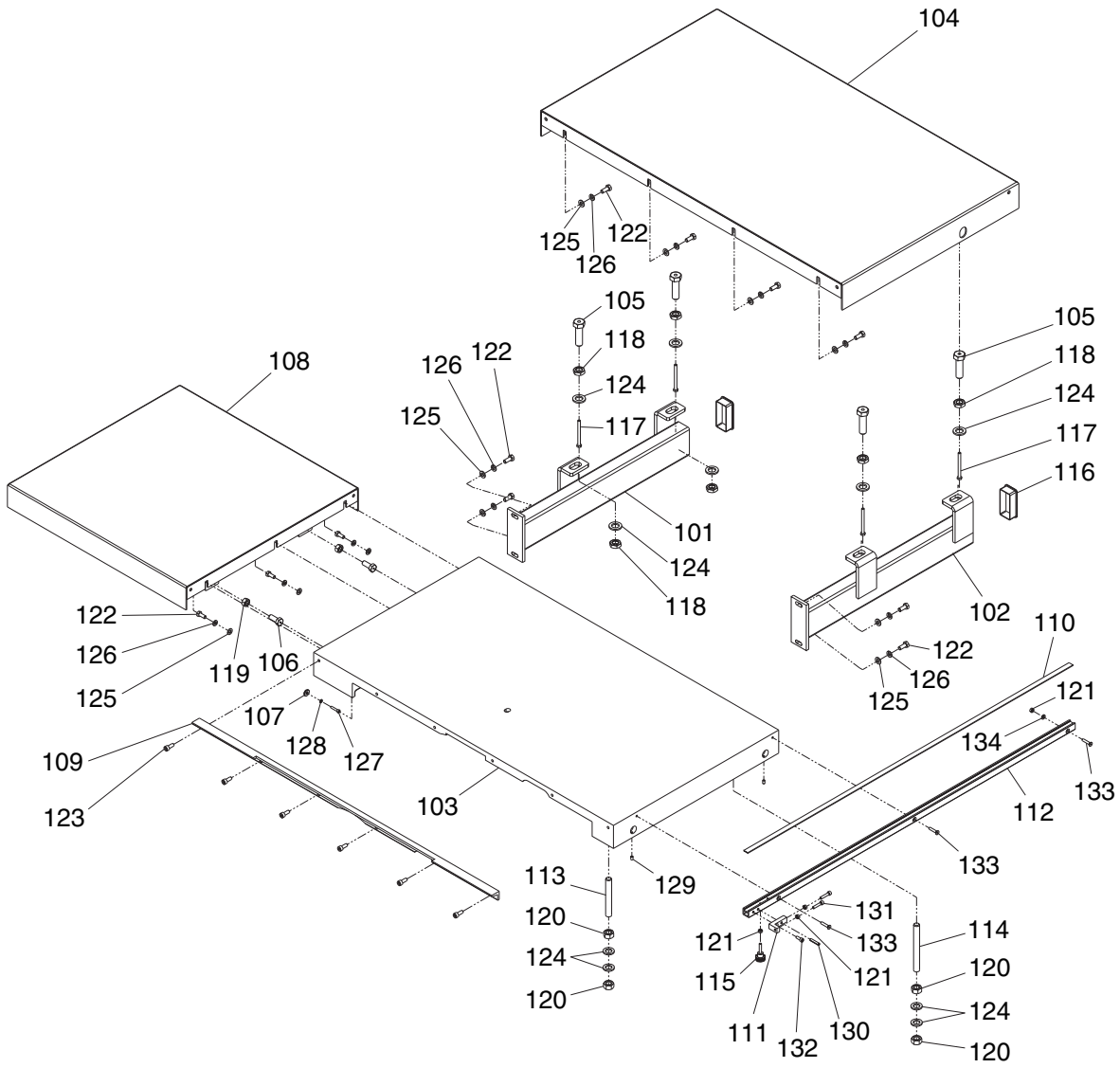
Body



Body Parts List

REF	PART #	DESCRIPTION
1	P07720001	TOOL HOLDER
2	P07720002	CONTROL PANEL ACCESS COVER
3	P07720003	TRUNNION (RIGHT)
4	P07720004	TRUNNION (LEFT)
5	P07720005	BLADE ANGLE ENCODER COVER
6	P07720006	ELECTRICAL PANEL DOOR
7	P07720007	ACCESS COVER
9	P07720009	SUPPORT ADJUSTMENT BASE
10	P07720010	HEX BOLT M20-2.5 X 350
11	P07720011	ENCODER MOUNTING PLATE
12	P07720012	ENCODER GEAR 18T
13	P07720013	SAW FRAME BODY
14	P07720014	BUTTON SWITCH RENY R9C10VN OFF
15	P07720015	BUTTON SWITCH RENY R9PDNV0 ON
16	P07720016	CONTROL PANEL
17	P07720017	CONTROL PANEL BACKPLATE
18	P07720018	CONTROL PANEL HOUSING
19	P07720019	BLADE COVER LIMIT SWITCH BRACKET
21	P07720021	SAW BODY COVER (FRONT)
22	P07720022	OPTICAL ENCODER HSK-XAO74
23	P07720023	MICRO CONTROLLER ETEK CH-525
24	P07720024	DOOR HANDLE/LATCH ASSEMBLY
25	P07720025	HINGE
26	P07720026	E-STOP BUTTON RENY R9C01VN
27	P07720027	DOOR LOCK
28	P07720028	FOOT STUD M16-2 X 70
29	P07720029	BUTTON HD CAP SCR M4-.7 X 8
30	P07720030	CAP SCREW M5-.8 X 12
31	P07720031	CAP SCREW M6-1 X 12
32	P07720032	BUTTON HD CAP SCR M6-1 X 12
33	P07720033	BUTTON HD CAP SCR M6-1 X 16
34	P07720034	LOCK WASHER 6MM
35	P07720035	HEX BOLT M10-1.5 X 120
36	P07720036	HEX NUT M10-1.5
37	P07720037	HEX BOLT M10-1.5 X 35
38	P07720038	CAP SCREW M4-.7 X 8
39	P07720039	SET SCREW M6-1 X 10
40	P07720040	FLAT WASHER 6MM
41	P07720041	CAP SCREW M10-1.5 X 30
42	P07720042	FLAT WASHER 10MM
43	P07720043	LOCK WASHER 10MM
44	P07720044	STRAIN RELIEF M25-1.5 TYPE-3
45	P07720045	CAP SCREW M8-1.25 X 16
46	P07720046	LOCK WASHER 8MM
47	P07720047	FLAT WASHER 8MM
48	P07720048	SET SCREW M10-1.5 X 30
49	P07720049	HOLE PLUG
50	P07720050	MASTER POWER SWITCH RENY R9C10VN
51	P07720051	HEX NUT M16-2
52	P07720052	FOOT M16-2
54	P07720054	LIMIT SWITCH QDQ CT-7312 250VAC 20A
60	P07720060	HEX NUT M20-2.5
61	P07720061	LOCK WASHER 20MM
62	P07720062	LOCK WASHER 4MM
63	P07720063	FLAT WASHER 4MM
64	P07720064	FLAT HD CAP SCR M4-.7 X 30
65	P07720065	MOTOR CABINET DOOR
66	P07720066	HEX NUT M4-.7
67	P07720067	SHAFT COLLAR

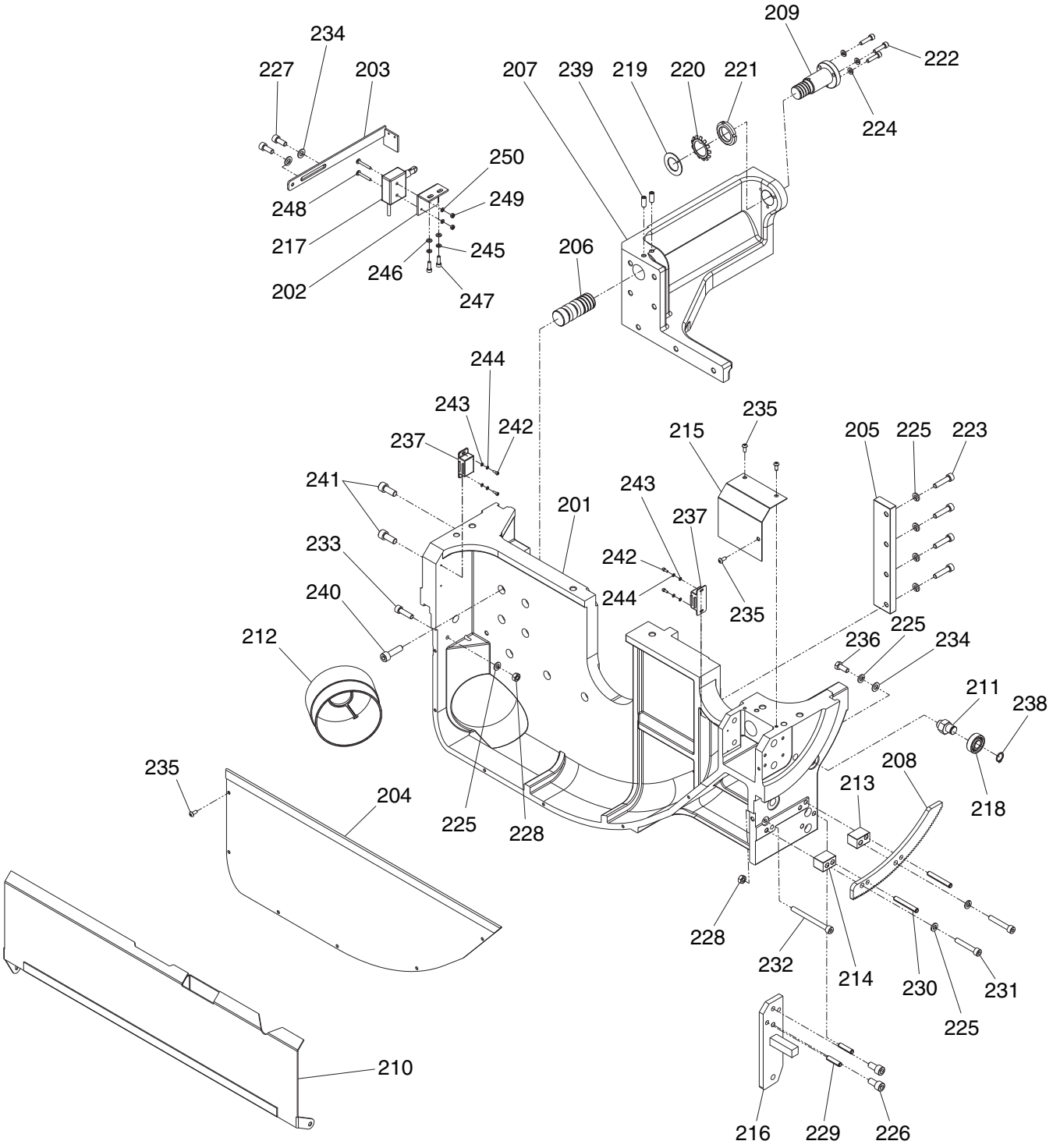
Tables



REF	PART #	DESCRIPTION
101	P07720101	EXTENSION TABLE SUPPORT (LEFT)
102	P07720102	EXTENSION TABLE SUPPORT (RIGHT)
103	P07720103	MAIN TABLE
104	P07720104	LARGE EXTENSION TABLE
105	P07720105	HEX BOLT M16-2 X 70, INT THREADS M6-1
106	P07720106	HEX BOLT M6-1 X 25
107	P07720107	FLAT WASHER 5MM
108	P07720108	SMALL EXTENSION TABLE
109	P07720109	TABLE INSERT
110	P07720110	RIP FENCE SCALE
111	P07720111	FENCE STOP BRACKET
112	P07720112	RIP FENCE SCALE BASE
113	P07720113	SET SCREW M16-2 X 120
114	P07720114	SET SCREW M16-2 X 150
115	P07720115	KNOB BOLT M6-1 X 30
116	P07720116	END-CAP 80 X 40MM
117	P07720117	HEX BOLT M6-1 X 70

REF	PART #	DESCRIPTION
118	P07720118	HEX NUT M16-2
119	P07720119	HEX NUT M6-1
120	P07720120	HEX NUT M16-2
121	P07720121	HEX NUT M6-1
122	P07720122	HEX BOLT M8-1.25 X 20
123	P07720123	CAP SCREW M8-1.25 X 20
124	P07720124	FLAT WASHER 16MM
125	P07720125	FLAT WASHER 8MM
126	P07720126	LOCK WASHER 8MM
127	P07720127	CAP SCREW M5-.8 X 25
128	P07720128	LOCK WASHER 5MM
129	P07720129	SET SCREW M6-1 X 10
130	P07720130	ROLL PIN 6 X 32
131	P07720131	CAP SCREW M6-1 X 30
132	P07720132	CAP SCREW M6-1 X 16
133	P07720133	FLAT HD CAP SCR M6-1 X 30
134	P07720134	FLAT WASHER 6MM

Blade Enclosure

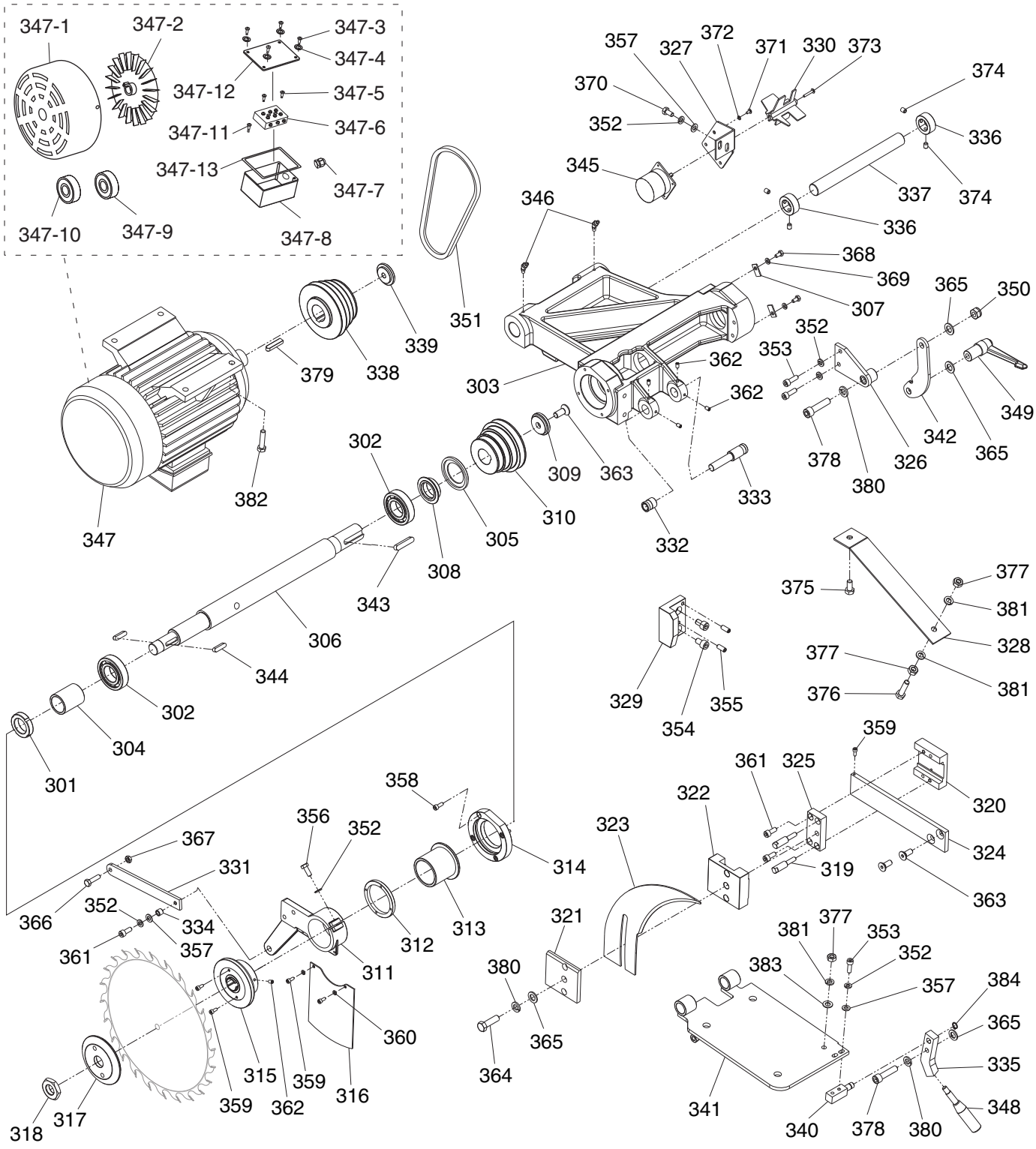


Blade Enclosure Parts List

REF	PART #	DESCRIPTION
201	P07720201	MOTOR MOUNT CASTING
202	P07720202	LIMIT SWITCH BRACKET
203	P07720203	LIMIT SWITCH STOP
204	P07720204	LOWER BLADE COVER (INNER)
205	P07720205	FIXED BAR
206	P07720206	PIVOT SHAFT
207	P07720207	MOTOR MOUNT PIVOT
208	P07720208	BLADE TILT RACK
209	P07720209	MOTOR MOUNT PIVOT FLANGE
210	P07720210	LOWER BLADE COVER (OUTER)
211	P07720211	ADJUSTMENT SHAFT
212	P07720212	DUST PORT 5"
213	P07720213	RACK MOUNTING BLOCK (RIGHT)
214	P07720214	RACK MOUNTING BLOCK (LEFT)
215	P07720215	MOTOR MOUNT COVER
216	P07720216	MOTOR MOUNT BRACKET
217	P07720217	LIMIT SWITCH QDQ CT-7312 20A
218	P07720218	BALL BEARING 6202ZZ
219	P07720219	PIVOT FLANGE FLAT WASHER 26MM
220	P07720220	EXT TOOTH WASHER 30MM
221	P07720221	SPANNER NUT M30-1.5
222	P07720222	CAP SCREW M6-1 X 25
223	P07720223	CAP SCREW M8-1.25 X 35
224	P07720224	LOCK WASHER 6MM
225	P07720225	LOCK WASHER 8MM

REF	PART #	DESCRIPTION
226	P07720226	CAP SCREW M10-1.5 X 20
227	P07720227	CAP SCREW M8-1.25 X 20
228	P07720228	HEX NUT M8-1.25
229	P07720229	ROLL PIN 8 X 32
230	P07720230	ROLL PIN 8 X 55
231	P07720231	CAP SCREW M8-1.25 X 50
232	P07720232	CAP SCREW M8-1.25 X 90
233	P07720233	CAP SCREW M8-1.25 X 30
234	P07720234	FLAT WASHER 8MM
235	P07720235	BUTTON HD CAP SCR M5-.8 X 12
236	P07720236	HEX BOLT M8-1.25 X 20
237	P07720237	LATCH MAGNET
238	P07720238	EXT RETAINING RING 15MM
239	P07720239	SET SCREW M8-1.25 X 20
240	P07720240	CAP SCREW M10-1.5 X 35
241	P07720241	CAP SCREW M10-1.5 X 25
242	P07720242	CAP SCREW M3-.5 X 8
243	P07720243	FLAT WASHER 3MM
244	P07720244	LOCK WASHER 3MM
245	P07720245	LOCK WASHER 5MM
246	P07720246	FLAT WASHER 5MM
247	P07720247	CAP SCREW M5-.8 X 16
248	P07720248	PHLP HD SCR M4-.7 X 30
249	P07720249	HEX NUT M4-.7
250	P07720250	LOCK WASHER 4MM

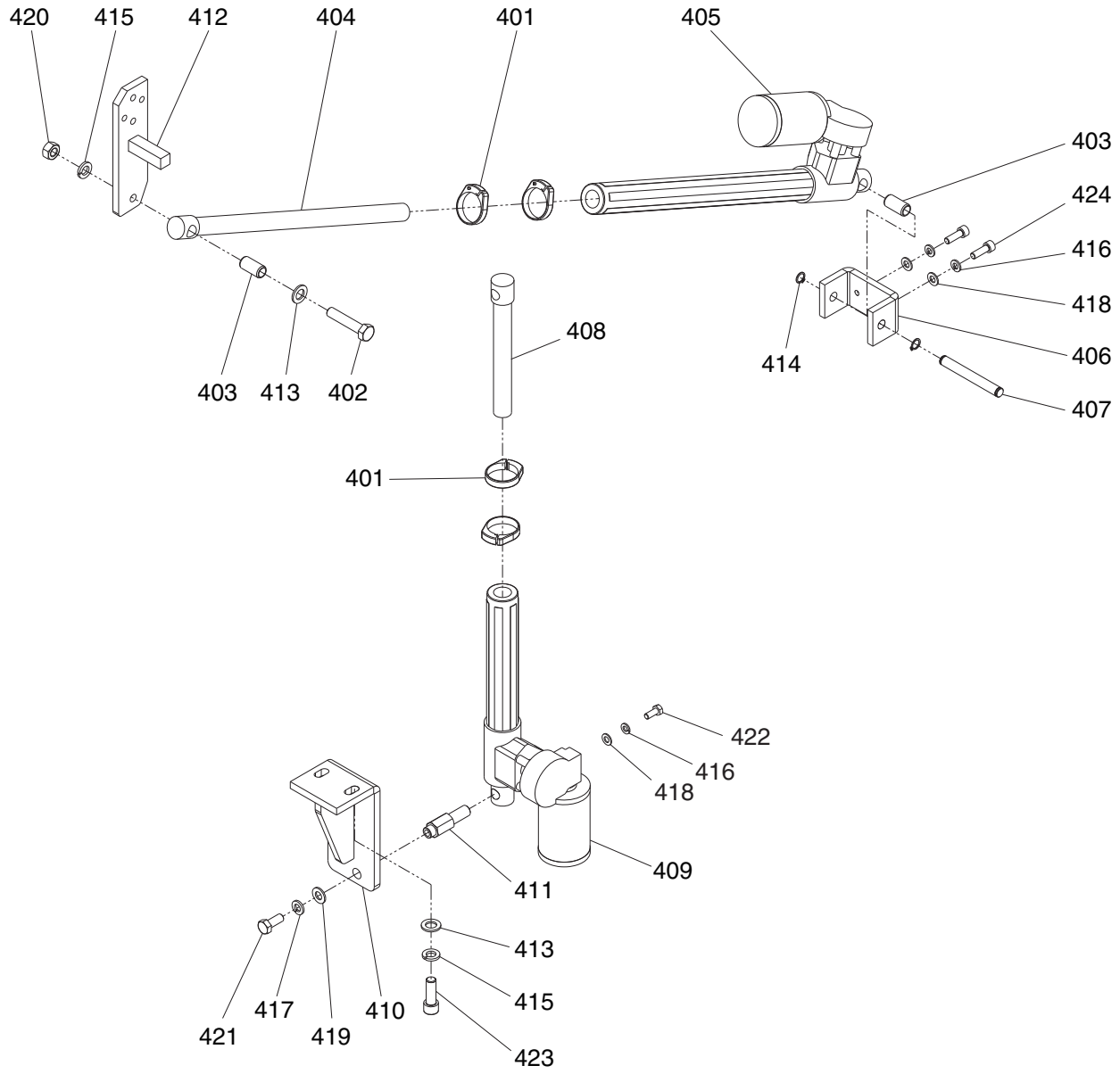
Main Blade Motor & Arbor



Main Blade Motor & Arbor Parts List

REF	PART #	DESCRIPTION
301	P07720301	SPANNER NUT M18-1.5
302	P07720302	BALL BEARING 6207ZZ
303	P07720303	ARBOR MOUNT
304	P07720304	BUSHING
305	P07720305	BEARING COVER
306	P07720306	MAIN BLADE ARBOR
307	P07720307	RETAINING CLIP
308	P07720308	BEARING SEAT
309	P07720309	ARBOR PULLEY COVER
310	P07720310	ARBOR PULLEY
311	P07720311	SUPPORT BRACKET
312	P07720312	ARBOR RING
313	P07720313	SUPPORT BUSHING
314	P07720314	BEARING COVER
315	P07720315	MAIN BLADE FLANGE (INNER)
316	P07720316	ARBOR COVER
317	P07720317	MAIN BLADE FLANGE (OUTER)
318	P07720318	ARBOR FLANGE NUT M25-2 LH
319	P07720319	LOCATOR PIN (RIVING KNIFE MOUNT)
320	P07720320	RIVING KNIFE MOUNT BLOCK (INNER)
321	P07720321	RIVING KNIFE ADJUSTMENT PLATE
322	P07720322	RIVING KNIFE ADJUSTMENT BLOCK
323	P07720323	RIVING KNIFE
324	P07720324	SLIDE RAIL (RIVING KNIFE MOUNT BLOCK)
325	P07720325	RIVING KNIFE MOUNT BLOCK (OUTER)
326	P07720326	ARBOR MOUNT BRACKET
327	P07720327	BLADE SPEED SWITCH BRACKET
328	P07720328	BELT TENSION FLAT SPRING
329	P07720329	AUXILIARY SLIDE RAIL
330	P07720330	BELT POSITION DETECTOR PLATE
331	P07720331	CONNECTING BAR
332	P07720332	BUSHING
333	P07720333	ARBOR MOUNT SHAFT (SMALL)
334	P07720334	SPACER
335	P07720335	MOTOR HANDLE BASE
336	P07720336	SHAFT COLLAR
337	P07720337	ARBOR MOUNT SHAFT (LARGE)
338	P07720338	MAIN MOTOR PULLEY
339	P07720339	MAIN MOTOR SHAFT CAP
340	P07720340	PIVOT AXIS
341	P07720341	MAIN MOTOR PIVOT PLATE
342	P07720342	ELBOW
343	P07720343	KEY 10 X 8 X 50
344	P07720344	KEY 8 X 7 X 32
345	P07720345	ROTARY SWITCH SHAN-HO TYPE-SC 10A
346	P07720346	GREASE FITTING M6-1 45-DEG
347	P07720347	MOTOR 10HP 220V/440V 3-PH
347-1	P07720347-1	MOTOR FAN COVER
347-2	P07720347-2	MOTOR FAN
347-3	P07720347-3	PHLP HD SCR M5-.8 X 10
347-4	P07720347-4	FLAT WASHER 5MM
347-5	P07720347-5	PHLP HD SCR M8-1.25 X 35
347-6	P07720347-6	MOTOR TERMINAL BLOCK
347-7	P07720347-7	STRAIN RELIEF M20-1.5 TYPE-5
347-8	P07720347-8	MOTOR TERMINAL BOX
347-9	P07720347-9	BALL BEARING 6308ZZ (FRONT)
347-10	P07720347-10	BALL BEARING 6306ZZ (REAR)
347-11	P07720347-11	PHLP HD SCR M8-1.25 X 16
347-12	P07720347-12	MOTOR TERMINAL BOX COVER
347-13	P07720347-13	GASKET
348	P07720348	HANDLE M10-1.5 X 137
349	P07720349	ADJUSTABLE HANDLE HL-95 M12-1.75
350	P07720350	LOCK NUT M12-1.75
351	P07720351	V-BELT 11M875
352	P07720352	LOCK WASHER 8MM
353	P07720353	CAP SCREW M8-1.25 X 20
354	P07720354	CAP SCREW M10-1.5 X 16
355	P07720355	SET SCREW M8-1.25 X 20
356	P07720356	HEX BOLT M8-1.25 X 20
357	P07720357	FLAT WASHER 8MM
358	P07720358	CAP SCREW M6-1 X 16
359	P07720359	CAP SCREW M5-.8 X 12
360	P07720360	LOCK WASHER 5MM
361	P07720361	CAP SCREW M8-1.25 X 20
362	P07720362	SET SCREW M6-1 X 10
363	P07720363	FLAT HD CAP SCR M10-1.5 X 25
364	P07720364	HEX BOLT M12-1.75 X 40
365	P07720365	FLAT WASHER 12MM
366	P07720366	HEX BOLT M8-1.25 X 30
367	P07720367	HEX NUT M8-1.25
368	P07720368	HEX BOLT M6-1 X 12
369	P07720369	LOCK WASHER 6MM
370	P07720370	HEX BOLT M8-1.25 X 16
371	P07720371	PHLP HD SCR M4-.7 X 8
372	P07720372	FLAT WASHER 4MM
373	P07720373	PHLP HD SCR M4-.7 X 25
374	P07720374	SET SCREW M8-1.25 X 10
375	P07720375	HEX BOLT M10-1.5 X 20
376	P07720376	HEX BOLT M10-1.5 X 40
377	P07720377	HEX NUT M10-1.5
378	P07720378	CAP SCREW M12-1.75 X 50
379	P07720379	KEY 10 X 8 X 45
380	P07720380	LOCK WASHER 12MM
381	P07720381	LOCK WASHER 10MM
382	P07720382	HEX BOLT M10-1.5 X 45
383	P07720383	FLAT WASHER 10MM
384	P07720384	EXT RETAINING RING 12MM

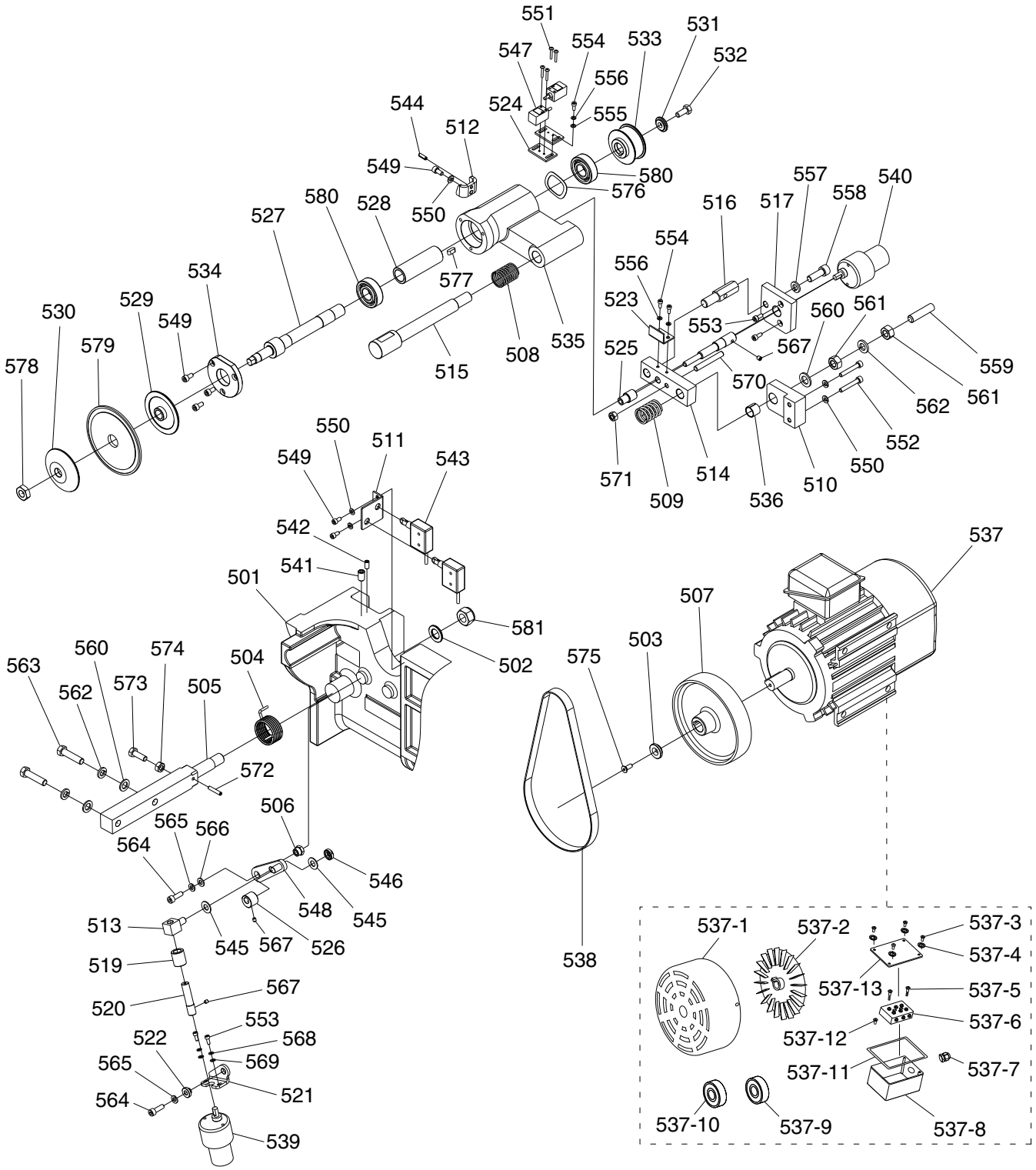
Blade Tilt System



REF	PART #	DESCRIPTION
401	P07720401	LIMIT SWITCH 24VDC
402	P07720402	HEX BOLT M12-1.75 X 60
403	P07720403	BUSHING
404	P07720404	ACTUATOR SHAFT (TILT)
405	P07720405	LINEAR ACTUATOR HIWIN LAI-1-1-350-24E
406	P07720406	BLADE TILT BRACKET
407	P07720407	BLADE TILT PIN
408	P07720408	ACTUATOR SHAFT (ELEVATION)
409	P07720409	LINEAR ACTUATOR APL0MB APL-3201
410	P07720410	ELEVATION BRACKET
411	P07720411	ELEVATION PIVOT AXIS
412	P07720412	BLADE TILT BRACKET (UPPER)

REF	PART #	DESCRIPTION
413	P07720413	FLAT WASHER 12MM
414	P07720414	EXT RETAINING RING 12MM
415	P07720415	LOCK WASHER 12MM
416	P07720416	LOCK WASHER 8MM
417	P07720417	LOCK WASHER 10MM
418	P07720418	FLAT WASHER 8MM
419	P07720419	FLAT WASHER 10MM
420	P07720420	HEX NUT M12-1.75
421	P07720421	HEX BOLT M10-1.5 X 25
422	P07720422	HEX BOLT M8-1.25 X 20
423	P07720423	CAP SCREW M12-1.75 X 35
424	P07720424	CAP SCREW M8-1.25 X 25

Scoring Blade Motor & Arbor

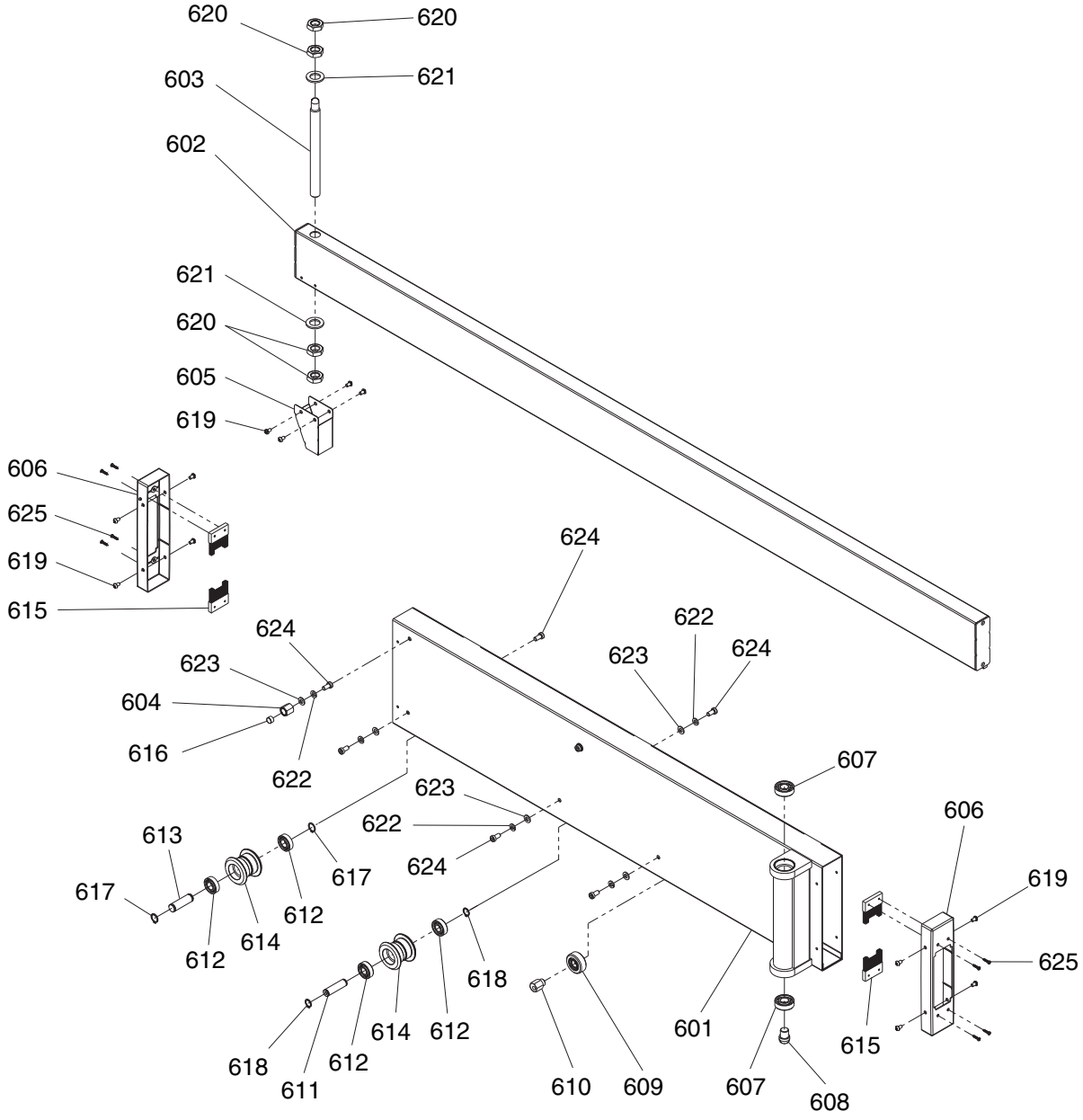


Scoring Blade Motor & Arbor Parts List

REF	PART #	DESCRIPTION
501	P07720501	SCORING SYSTEM CHASSIS
502	P07720502	FLAT WASHER 20MM
503	P07720503	PULLEY LOCK RING
504	P07720504	TORSION SPRING
505	P07720505	PIVOT AXIS
506	P07720506	PIVOT NUT
507	P07720507	SCORING MOTOR PULLEY
508	P07720508	COMPRESSION SPRING
509	P07720509	COMPRESSION SPRING
510	P07720510	PIVOT BLOCK
511	P07720511	LIMIT SWITCH MOUNTING BRACKET
512	P07720512	LIMIT SWITCH STOP
513	P07720513	LEADSCREW NUT
514	P07720514	MOUNTING BLOCK
515	P07720515	PIVOT SHAFT
516	P07720516	SHAFT
517	P07720517	DC MOTOR BASE
519	P07720519	BUSHING
520	P07720520	LEADSCREW
521	P07720521	DC MOTOR BRACKET
522	P07720522	MOTOR BRACKET LOCK RING
523	P07720523	LIMIT SWITCH STOP
524	P07720524	LIMIT SWITCH BRACKET
525	P07720525	ADJUSTMENT SCREW
526	P07720526	ADJUSTMENT CAM
527	P07720527	SCORING BLADE SPINDLE
528	P07720528	SPINDLE SLEEVE
529	P07720529	INNER SCORING FLANGE
530	P07720530	OUTER SCORING FLANGE
531	P07720531	PULLEY LOCK RING
532	P07720532	SCORING SPINDLE BOLT
533	P07720533	SCORING SPINDLE PULLEY
534	P07720534	BEARING COVER
535	P07720535	SCORING SPINDLE HOUSING
536	P07720536	BUSHING
537	P07720537	MOTOR 1HP 220V/440V 3-PH
537-1	P07720537-1	MOTOR FAN COVER
537-2	P07720537-2	MOTOR FAN
537-3	P07720537-3	PHLP HD SCR M4-.7 X 8
537-4	P07720537-4	FLAT WASHER 4MM
537-5	P07720537-5	PHLP HD SCR M5-.8 X 10
537-6	P07720537-6	MOTOR TERMINAL
537-7	P07720537-7	STRAIN RELIEF TYPE-3
537-8	P07720537-8	MOTOR TERMINAL BOX
537-9	P07720537-9	BALL BEARING 6201ZZ (FRONT)
537-10	P07720537-10	BALL BEARING 6203ZZ (REAR)
537-11	P07720537-11	GASKET

REF	PART #	DESCRIPTION
537-12	P07720537-12	FLANGE BOLT M5-.8 X 20
537-13	P07720537-13	MOTOR TERMINAL BOX COVER
538	P07720538	FLAT BELT 15 X 690MM
539	P07720539	DC MOTOR JYE MAW JM189E-3450
540	P07720540	DC MOTOR JYE MAW JM189E-3450
541	P07720541	SET SCREW M12-1.75 X 20
542	P07720542	SET SCREW M8-1.25 X 16
543	P07720543	LIMIT SWITCH QDQ CT-7312
544	P07720544	ROLL PIN 5 X 16
545	P07720545	THRUST WASHER 12MM
546	P07720546	LOCK NUT M12-1.75
547	P07720547	PROXIMITY SWITCH OMRON TL-Q5MC1
548	P07720548	SCORING BLADE HEIGHT PIVOT ARM
549	P07720549	CAP SCREW M6-1 X 12
550	P07720550	LOCK WASHER 6MM
551	P07720551	PHLP HD SCR M3-.5 X 20
552	P07720552	CAP SCREW M6-1 X 40
553	P07720553	CAP SCREW M5-.8 X 12
554	P07720554	CAP SCREW M4-.7 X 10
555	P07720555	FLAT WASHER 4MM
556	P07720556	LOCK WASHER 4MM
557	P07720557	LOCK WASHER 10MM
558	P07720558	CAP SCREW M10-1.5 X 30
559	P07720559	SET SCREW M12-1.75 X 50
560	P07720560	FLAT WASHER 12MM
561	P07720561	HEX NUT M12-1.75
562	P07720562	LOCK WASHER 12MM
563	P07720563	HEX BOLT M12-1.75 X 50
564	P07720564	CAP SCREW M8-1.25 X 25
565	P07720565	LOCK WASHER 8MM
566	P07720566	FLAT WASHER 8MM
567	P07720567	SET SCREW M6-1 X 6
568	P07720568	LOCK WASHER 5MM
569	P07720569	FLAT WASHER 5MM
570	P07720570	SET SCREW M8-1.25 X 60
571	P07720571	HEX NUT M8-1.25
572	P07720572	ROLL PIN 6 X 32
573	P07720573	HEX BOLT M10-1.5 X 30
574	P07720574	HEX NUT M10-1.5
575	P07720575	FLAT HD CAP SCR M6-1 X 16
576	P07720576	WAVY WASHER
577	P07720577	KEY 6 X 6 X 15
578	P07720578	HEX NUT M14-2 THIN
579	P07720579	SCORING BLADE SET 120 X 22MM
580	P07720580	BALL BEARING 6204-2NSE-CM
581	P07720581	LOCK NUT M20-2.5

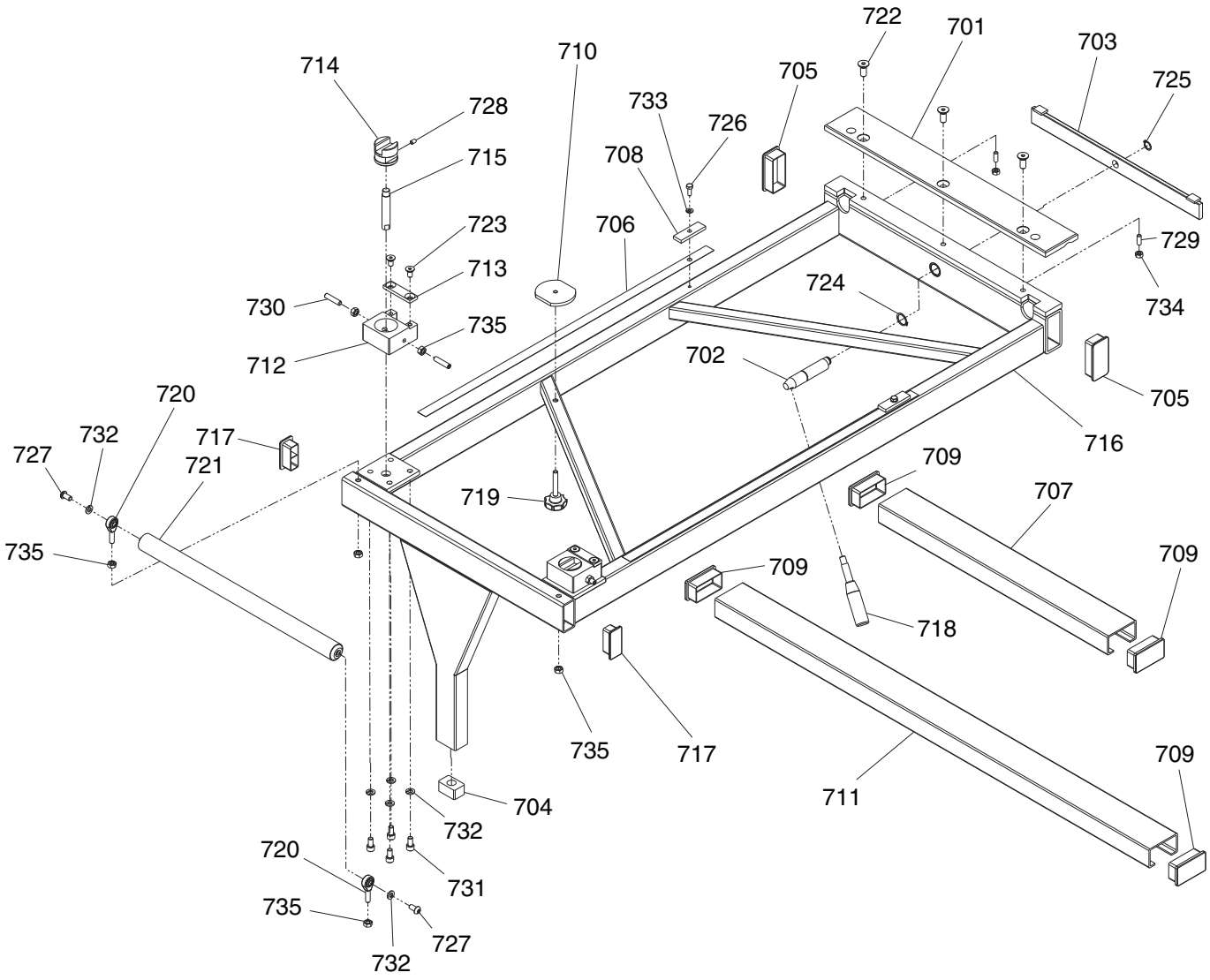
Crosscut Table Swing Arm



REF	PART #	DESCRIPTION
601	P07720601	CROSSCUT SWING ARM
602	P07720602	CROSSCUT SWING ARM EXTENSION
603	P07720603	THREADED SHAFT M20-2.5 X 220
604	P07720604	MAGNET HOUSING
605	P07720605	SWING ARM EXTENSION END COVER
606	P07720606	SWING ARM END COVER
607	P07720607	BALL BEARING 6203ZZ
608	P07720608	SWING ARM PIVOT SHAFT
609	P07720609	GUIDE WHEEL
610	P07720610	GUIDE WHEEL CAM
611	P07720611	ROLLER SHAFT
612	P07720612	BALL BEARING 6202ZZ
613	P07720613	ADJUSTMENT SHAFT

REF	PART #	DESCRIPTION
614	P07720614	ROLLER
615	P07720615	BRISTLE BRUSH
616	P07720616	MAGNET
617	P07720617	EXT RETAINING RING 17MM
618	P07720618	EXT RETAINING RING 15MM
619	P07720619	BUTTON HD CAP SCR M6-1 X 10
620	P07720620	HEX NUT M20-2.5 THIN
621	P07720621	FLAT WASHER 20MM
622	P07720622	LOCK WASHER 8MM
623	P07720623	FLAT WASHER 8MM
624	P07720624	CAP SCREW M8-1.25 X 16
625	P07720625	TAP SCREW M4 X 12

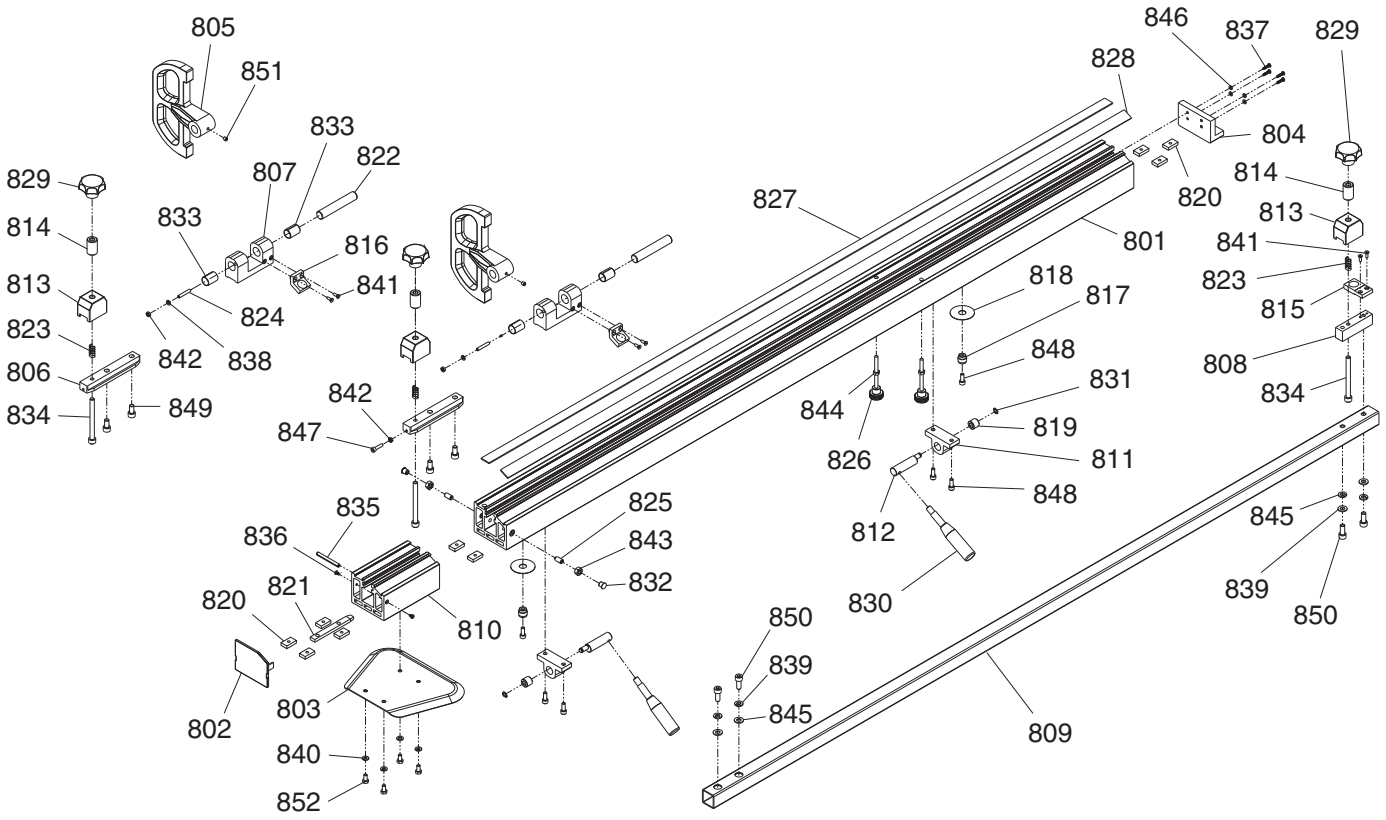
Crosscut Table



REF	PART #	DESCRIPTION
701	P07720701	CROSSCUT TABLE GUIDE PLATE
702	P07720702	ADJUSTMENT SHAFT
703	P07720703	LOCK BAR
704	P07720704	CROSSCUT FRAME PIVOT BLOCK
705	P07720705	END-CAP 80 X 40MM
706	P07720706	ANTI-FRICTION STRIP
707	P07720707	FRAME BRACE (SHORT)
708	P07720708	GUIDE BLOCK
709	P07720709	END-CAP 70 X 40MM
710	P07720710	CLAMP PLATE
711	P07720711	FRAME BRACE (LONG)
712	P07720712	CLAMP BASE
713	P07720713	CLAMP BAR
714	P07720714	CLAMP ADJUSTMENT NUT
715	P07720715	CLAMP ADJUSTMENT SHAFT
716	P07720716	CROSSCUT TABLE FRAME
717	P07720717	END-CAP 60 X 30MM
718	P07720718	LEVER HANDLE 100L M10-1.5 X 14

REF	PART #	DESCRIPTION
719	P07720719	KNOB BOLT M8-1.25 X 50
720	P07720720	ROLLER EYE BOLT M8-1.25 X 28
721	P07720721	ROLLER
722	P07720722	FLAT HD CAP SCR M10-1.5 X 25
723	P07720723	FLAT HD CAP SCR M8-1.25 X 16
724	P07720724	EXT RETAINING RING 20MM
725	P07720725	EXT RETAINING RING 14MM
726	P07720726	HEX BOLT M6-1 X 16
727	P07720727	BUTTON HD CAP SCR M8-1.25 X 16
728	P07720728	SET SCREW M6-1 X 10
729	P07720729	SET SCREW M6-1 X 16
730	P07720730	SET SCREW M8-1.25 X 35
731	P07720731	CAP SCREW M8-1.25 X 16
732	P07720732	LOCK WASHER 8MM
733	P07720733	LOCK WASHER 6MM
734	P07720734	HEX NUT M6-1
735	P07720735	HEX NUT M8-1.25

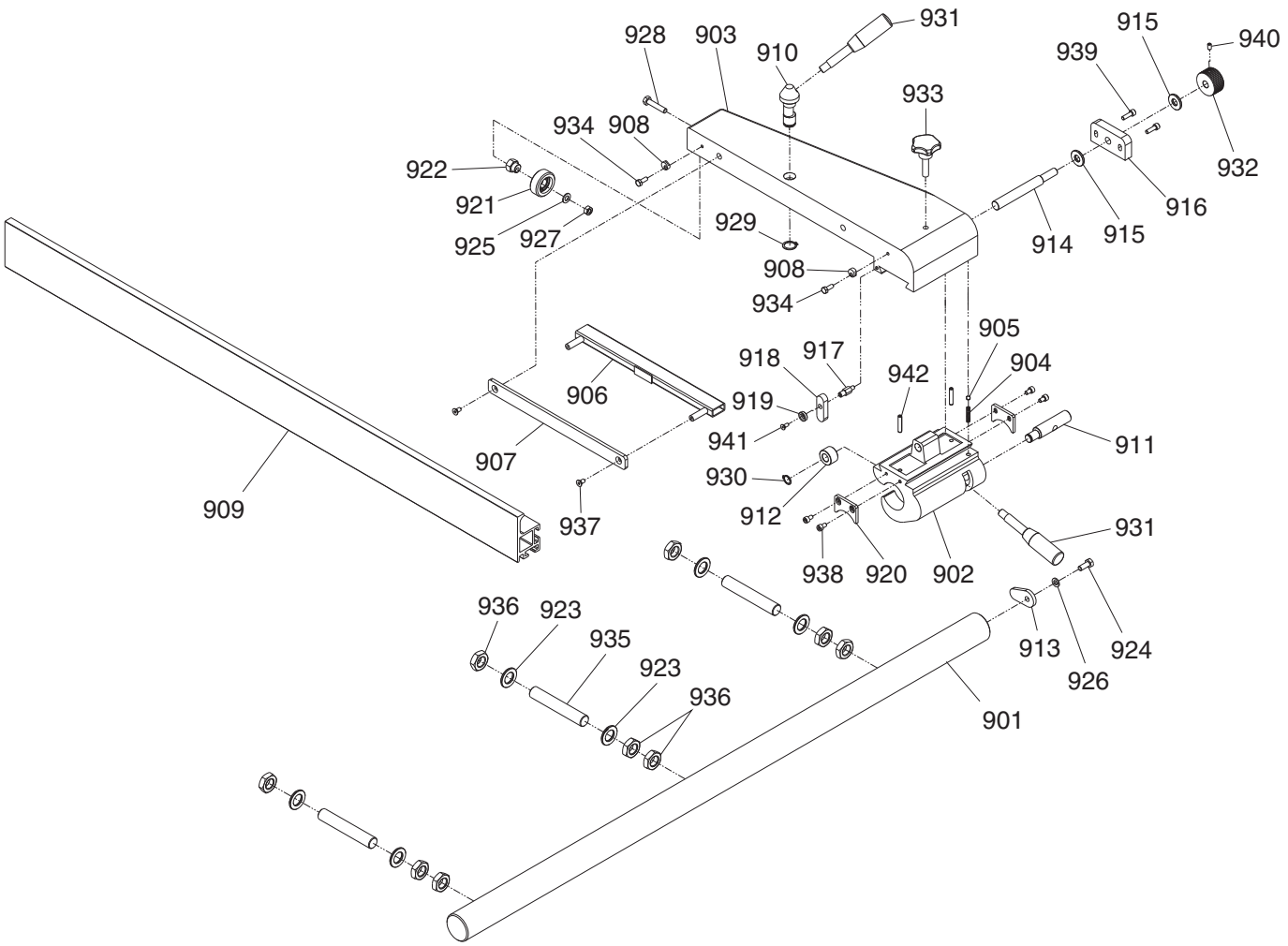
Crosscut Fence



REF	PART #	DESCRIPTION
801	P07720801	CROSSCUT FENCE
802	P07720802	EXTENSION FENCE END-CAP
803	P07720803	STOCK SUPPORT PLATE
804	P07720804	CROSSCUT FENCE END-CAP
805	P07720805	FLIP STOP
806	P07720806	LOCKING FLIP STOP SLIDE
807	P07720807	FLIP STOP BRACKET
808	P07720808	LOCKING SLIDE
809	P07720809	CROSSCUT POSITIONER
810	P07720810	CROSSCUT EXTENSION FENCE
811	P07720811	LOCKING BASE
812	P07720812	LOCKING CAM
813	P07720813	LOCKING SLIDE BLOCK
814	P07720814	BUSHING
815	P07720815	MAGNIFIER (STRAIGHT)
816	P07720816	MAGNIFIER (ANGLED)
817	P07720817	FENCE PIVOT PIN
818	P07720818	FLAT WASHER 6MM
819	P07720819	LOCKING WHEEL
820	P07720820	POSITIONING BLOCK
821	P07720821	POSITIONING BAR
822	P07720822	PIVOT SHAFT
823	P07720823	COMPRESSION SPRING
824	P07720824	SET SCREW M5-.8 X 35 (PLASTIC TIP)
825	P07720825	SET SCREW M8-1.25 X 16 (PLASTIC)
826	P07720826	KNOB BOLT M6-1 X 74-CONE PT

REF	PART #	DESCRIPTION
827	P07720827	FENCE SCALE 0"-66"
828	P07720828	FENCE SCALE 66"-129"
829	P07720829	KNOB M8-1.25 7-LOBE
830	P07720830	LEVER HANDLE 125L M10-1.5 X 14
831	P07720831	EXT RETAINING RING 8MM
832	P07720832	HOLE PLUG
833	P07720833	BUSHING
834	P07720834	CAP SCREW M8-1.25 X 90
835	P07720835	ROLL PIN 6 X 56
836	P07720836	PLUG 1/8" X 3/8"
837	P07720837	PLUG 1/8" X 3/4"
838	P07720838	LOCK WASHER 5MM
839	P07720839	LOCK WASHER 8MM
840	P07720840	LOCK WASHER 6MM
841	P07720841	FLAT HD CAP SCR M4-.7 X 12
842	P07720842	HEX NUT M5-.8
843	P07720843	HEX NUT M8-1.25
844	P07720844	HEX NUT M6-1
845	P07720845	FLAT WASHER 8MM
846	P07720846	FLAT WASHER 4MM
847	P07720847	CAP SCREW M5-.8 X 20
848	P07720848	CAP SCREW M6-1 X 16
849	P07720849	CAP SCREW M8-1.25 X 16
850	P07720850	CAP SCREW M8-1.25 X 20
851	P07720851	SET SCREW M6-1 X 6
852	P07720852	HEX BOLT M6-1 X 12

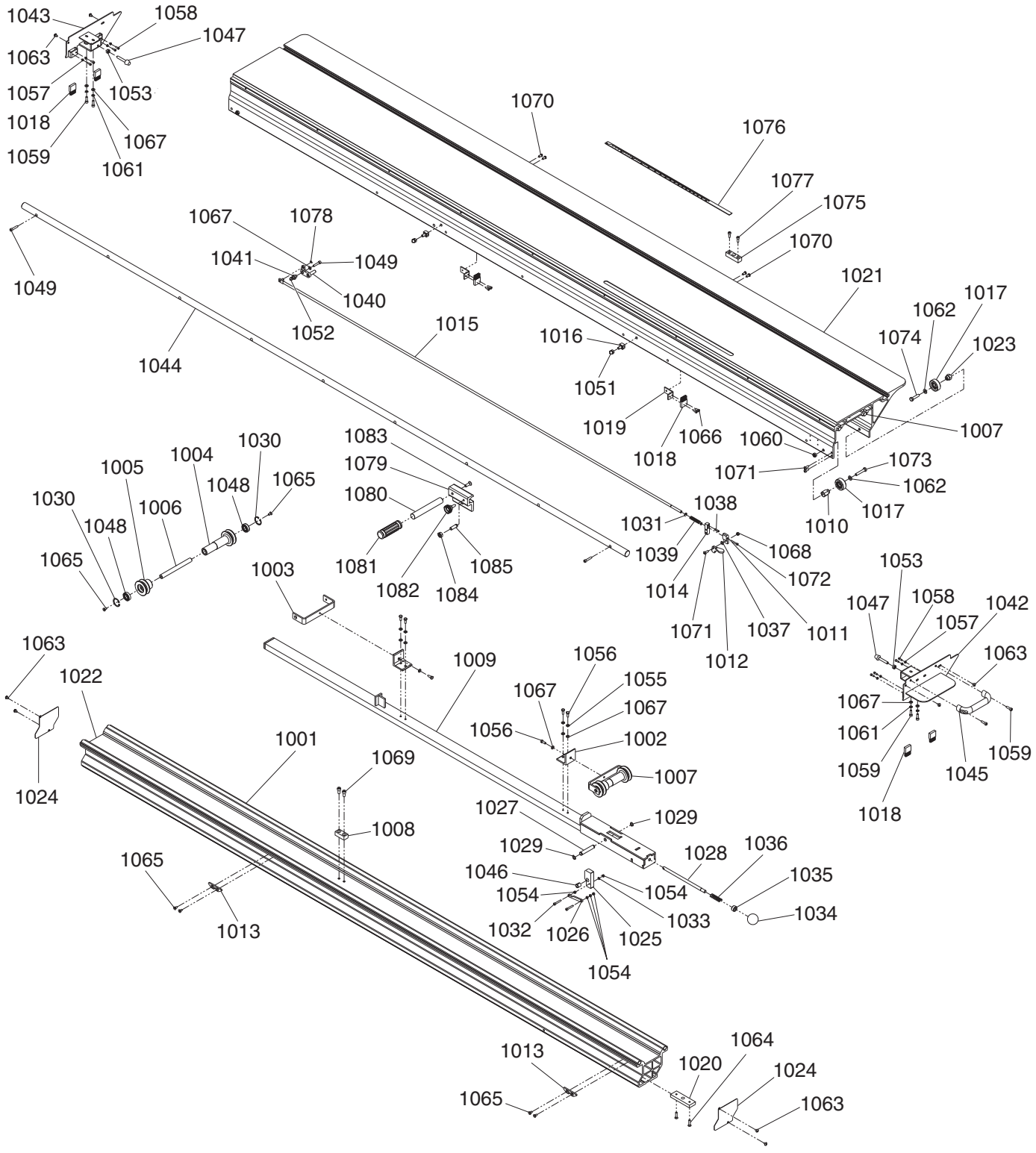
Rip Fence



REF	PART #	DESCRIPTION
901	P07720901	RIP FENCE RAIL
902	P07720902	RIP FENCE SLIDE BASE
903	P07720903	RIP FENCE BODY
904	P07720904	COMPRESSION SPRING
905	P07720905	STEEL BALL 6MM
906	P07720906	ALIGNMENT PLATE
907	P07720907	FENCE T-SLOT PLATE
908	P07720908	GUIDE WHEEL
909	P07720909	RIP FENCE 47-1/2" ALUMINUM
910	P07720910	ECCENTRIC SHAFT
911	P07720911	FIXED SHAFT
912	P07720912	LOCK RING
913	P07720913	RAIL END PLATE
914	P07720914	ADJUSTMENT SHAFT
915	P07720915	FLAT WASHER 12MM BRASS
916	P07720916	FIXED BASE
917	P07720917	GUIDE KEY SHAFT
918	P07720918	GUIDE KEY
919	P07720919	SPACER
920	P07720920	RAIL WIPER
921	P07720921	GUIDE WHEEL

REF	PART #	DESCRIPTION
922	P07720922	GUIDE WHEEL CAM
923	P07720923	FLAT WASHER 20MM
924	P07720924	HEX BOLT M8-1.25 X 20
925	P07720925	FLAT WASHER 8MM
926	P07720926	LOCK WASHER 8MM
927	P07720927	HEX NUT M8-1.25
928	P07720928	HEX BOLT M8-1.25 X 40
929	P07720929	EXT RETAINING RING 20MM
930	P07720930	EXT RETAINING RING 14MM
931	P07720931	LEVER HANDLE 125L M12-1.75 X 16
932	P07720932	MICRO-ADJUST KNOB
933	P07720933	KNOB BOLT M10-1.5 X 30 5-LOBE
934	P07720934	HEX BOLT M6-1 X 16
935	P07720935	SET SCREW M20-2.5 X 120
936	P07720936	HEX NUT M20-2.5
937	P07720937	FLAT HD CAP SCR M6-1 X 12
938	P07720938	CAP SCREW M6-1 X 10
939	P07720939	CAP SCREW M6-1 X 20
940	P07720940	SET SCREW M6-1 X 10
941	P07720941	FLAT HD CAP SCR M5-.8 X 12
942	P07720942	ROLL PIN 6 X 32

Sliding Table

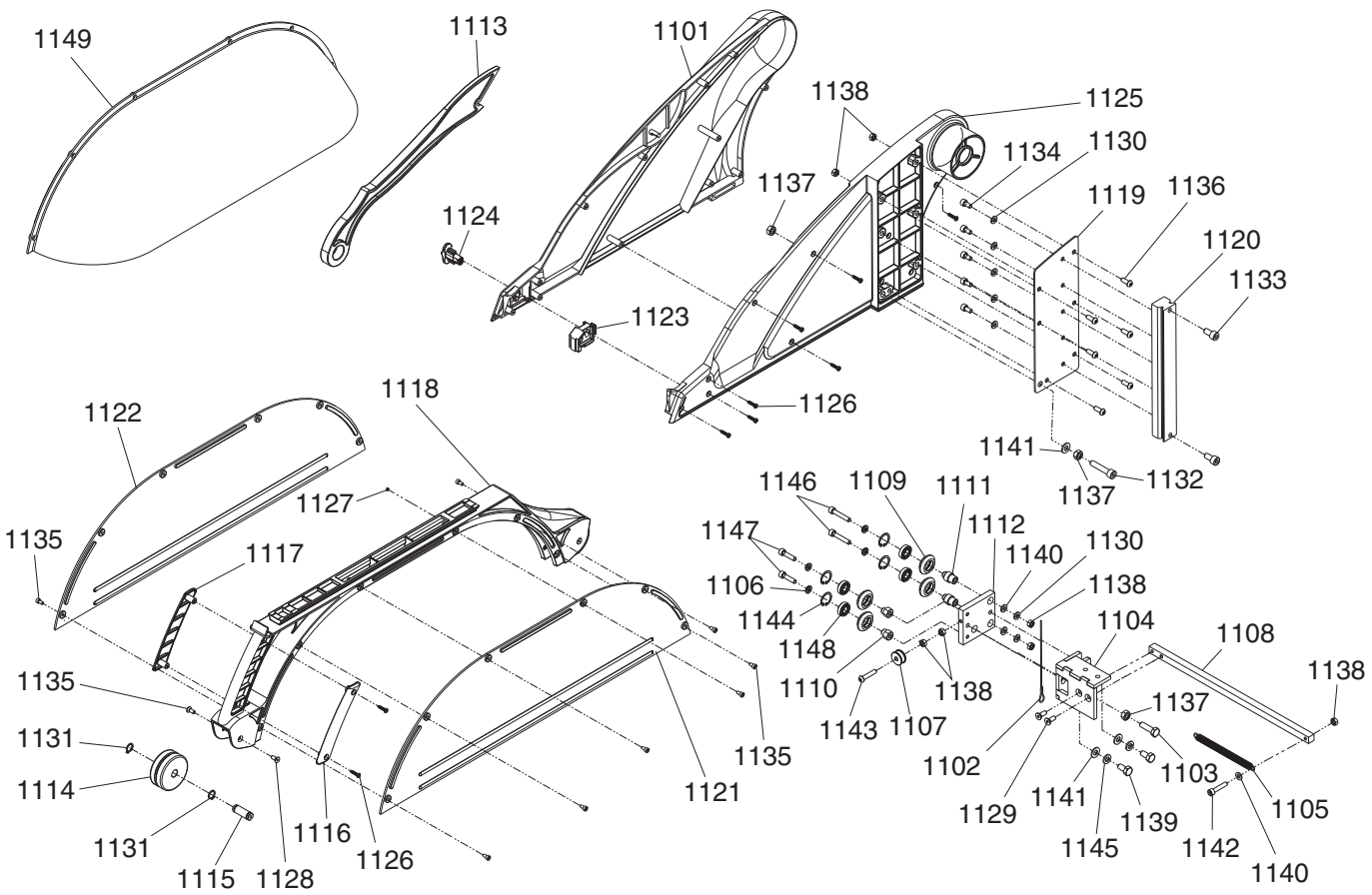


Sliding Table Parts List

REF	PART #	DESCRIPTION
1001	P07721001	SLIDING TABLE GUIDE BASE
1002	P07721002	L-BRACKET
1003	P07721003	GUIDE WHEEL BRACKET
1004	P07721004	GUIDE WHEEL W/SHAFT
1005	P07721005	GUIDE WHEEL
1006	P07721006	GUIDE WHEEL SHAFT
1007	P07721007	ROLLER GUIDE
1008	P07721008	STOP BLOCK
1009	P07721009	SLIDE BAR
1010	P07721010	GUIDE WHEEL CAM
1011	P07721011	STOP BLOCK
1012	P07721012	LOCK HANDLE
1013	P07721013	POSITIONING BLOCK
1014	P07721014	FIXED BLOCK
1015	P07721015	LOCK ROD
1016	P07721016	ROD GUIDE
1017	P07721017	GUIDE WHEEL
1018	P07721018	BRISTLE BRUSH
1019	P07721019	BRISTLE BRUSH BRACKET
1020	P07721020	LOCK BLOCK
1021	P07721021	SLIDING TABLE
1022	P07721022	SLIDING TABLE BASE
1023	P07721023	GUIDE WHEEL CAM
1024	P07721024	SLIDING TABLE BASE END-CAP
1025	P07721025	STOP BLOCK
1026	P07721026	STOP BLOCK ARM
1027	P07721027	HEADLESS CLEAVIS PIN 12MM
1028	P07721028	TABLE RELEASE KNOB STUD
1029	P07721029	EXT RETAINING RING 12MM
1030	P07721030	INT RETAINING RING 32MM
1031	P07721031	E-CLIP 6MM
1032	P07721032	CAP SCREW M5-.8 X 30
1033	P07721033	LOCK WASHER 5MM
1034	P07721034	ROUND KNOB
1035	P07721035	SPACER
1036	P07721036	COMPRESSION SPRING
1037	P07721037	FLAT WASHER 6MM
1038	P07721038	ROLL PIN 5 X 20
1039	P07721039	COMPRESSION SPRING
1040	P07721040	LOCK ROD LINKAGE ROCKER
1041	P07721041	PIVOT NUT
1042	P07721042	SLIDING TABLE END-CAP (FRONT)

REF	PART #	DESCRIPTION
1043	P07721043	SLIDING TABLE END-CAP (REAR)
1044	P07721044	SLIDE RAIL
1045	P07721045	SLIDING TABLE HANDLE
1046	P07721046	BUSHING
1047	P07721047	RUBBER STOP M8-1.25 X 45, 65L
1048	P07721048	BALL BEARING 6002-2RS
1049	P07721049	CAP SCREW M6-1 X 30
1051	P07721051	ACORN NUT M8-1.25
1052	P07721052	ACORN NUT M6-1
1053	P07721053	HEX NUT M8-1.25
1054	P07721054	HEX NUT M5-.8
1055	P07721055	LOCK WASHER 6MM
1056	P07721056	HEX BOLT M6-1 X 16
1057	P07721057	HEX BOLT M6-1 X 16
1058	P07721058	CAP SCREW M4-.7 X 12
1059	P07721059	CAP SCREW M6-1 X 20
1060	P07721060	LOCK NUT M8-1.25
1061	P07721061	LOCK WASHER 6MM
1062	P07721062	FLAT WASHER 8MM
1063	P07721063	PHLP HD SCR M5-.8 X 8
1064	P07721064	BUTTON HD CAP SCR M6-1 X 25
1065	P07721065	FLAT HD CAP SCR M6-1 X 12
1066	P07721066	CAP SCREW M5-.8 X 12
1067	P07721067	FLAT WASHER 6MM
1068	P07721068	HEX NUT M6-1
1069	P07721069	CAP SCREW M8-1.25 X 16
1070	P07721070	BUTTON HD CAP SCR M6-1 X 12
1071	P07721071	BUTTON HD CAP SCR M6-1 X 16
1072	P07721072	CAP SCREW M4-.7 X 30
1073	P07721073	HEX BOLT M8-1.25 X 45
1074	P07721074	HEX BOLT M8-1.25 X 35
1075	P07721075	POSITIONING BLOCK
1076	P07721076	SLIDING TABLE SCALE
1077	P07721077	CAP SCREW M6-1 X 16
1078	P07721078	E-CLIP 4MM
1079	P07721079	FIXED BLOCK
1080	P07721080	HANDLE
1081	P07721081	HANDLE SLEEVE
1082	P07721082	KNOB BOLT M8-1.25 X 20
1083	P07721083	FLAT HD CAP SCR M8-1.25 X 25
1084	P07721084	HEX NUT M10-1.5
1085	P07721085	STUD M10-1.5 X 85 PLASTIC TIP

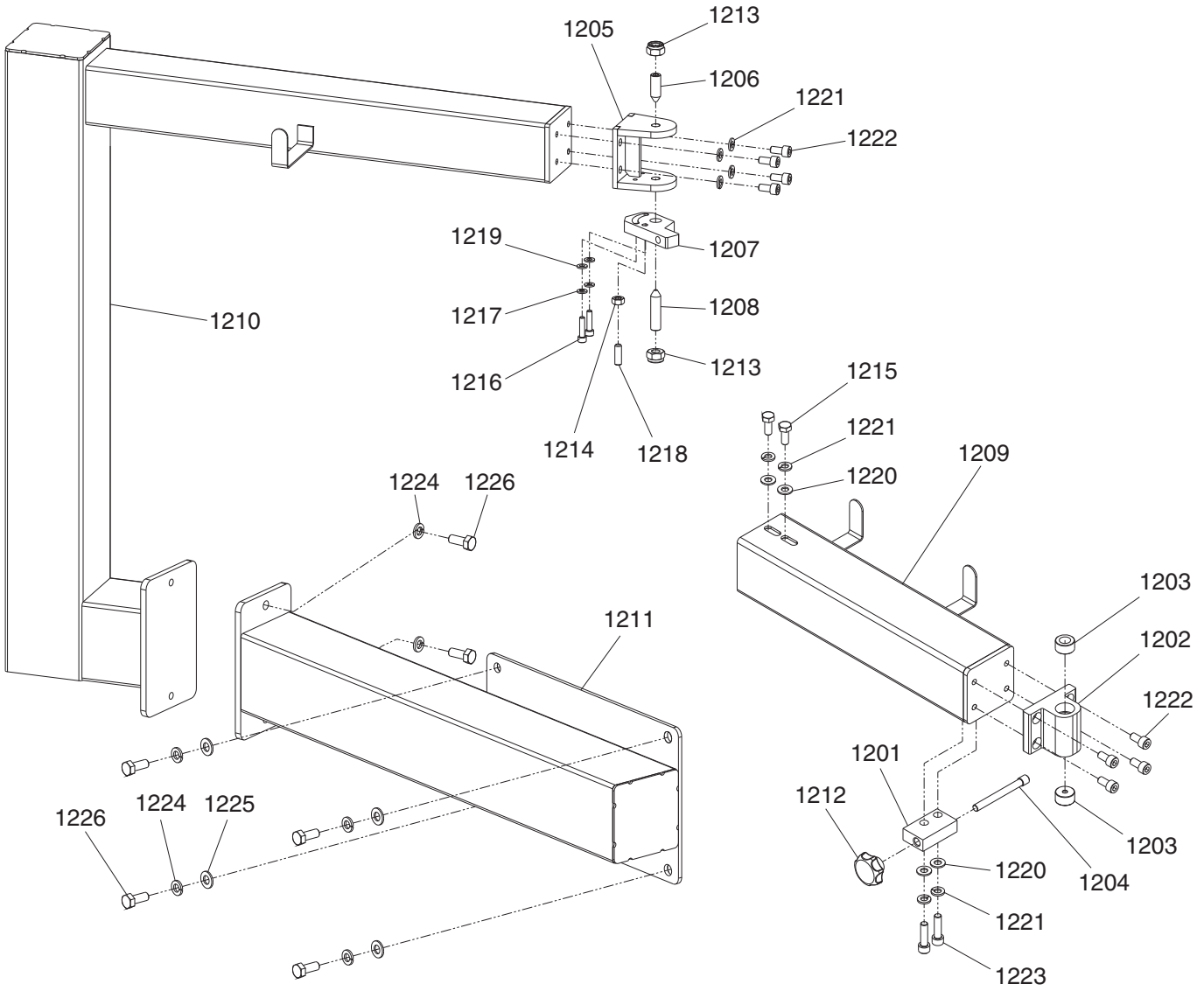
Blade Guard



REF	PART #	DESCRIPTION
1101	P07721101	BLADE GUARD HOUSING (LEFT)
1102	P07721102	TENSIONING CABLE
1103	P07721103	SPECIAL HEX BOLT M8-1.25 X 30
1104	P07721104	GUIDE WHEEL BASE BRACKET
1105	P07721105	EXTENSION SPRING
1106	P07721106	FLAT WASHER 6MM
1107	P07721107	GUIDE WHEEL
1108	P07721108	SPRING MOUNT
1109	P07721109	GUIDE WHEEL
1110	P07721110	GUIDE WHEEL SHAFT (ADJUSTABLE)
1111	P07721111	GUIDE WHEEL SHAFT (FIXED)
1112	P07721112	GUIDE WHEEL BASE
1113	P07721113	PUSH STICK
1114	P07721114	ROLLER
1115	P07721115	ROLLER SHAFT
1116	P07721116	COVER GRIP (RIGHT)
1117	P07721117	COVER GRIP (LEFT)
1118	P07721118	GUARD BASE
1119	P07721119	WHEEL GUIDE MOUNT
1120	P07721120	WHEEL GUIDE
1121	P07721121	FLAT BLADE GUARD (RIGHT)
1122	P07721122	FLAT BLADE GUARD (LEFT)
1123	P07721123	BLADE GUARD OPEN/LOCK BASE
1124	P07721124	BLASÉ GUARD OPEN/LOCK SWITCH
1125	P07721125	BLADE GUARD HOUSING (RIGHT)

REF	PART #	DESCRIPTION
1126	P07721126	PLUG 1/8" X 3/4"
1127	P07721127	HEX NUT M4-.7
1128	P07721128	FLAT HD CAP SCR M5-.8 X 12
1129	P07721129	FLAT HD CAP SCR M6-1 X 16
1130	P07721130	LOCK WASHER 6MM
1131	P07721131	EXT RETAINING RING 12MM
1132	P07721132	CAP SCREW M8-1.25 X 40
1133	P07721133	CAP SCREW M8-1.25 X 16
1134	P07721134	CAP SCREW M6-1 X 12
1135	P07721135	CAP SCREW M4-.7 X 8
1136	P07721136	BUTTON HD CAP SCR M6-1 X 16
1137	P07721137	HEX NUT M8-1.25
1138	P07721138	HEX NUT M6-1
1139	P07721139	HEX BOLT M8-1.25 X 16
1140	P07721140	FLAT WASHER 6MM
1141	P07721141	FLAT WASHER 8MM
1142	P07721142	CAP SCREW M6-1 X 30
1143	P07721143	BUTTON HD CAP SCR M6-1 X 30
1144	P07721144	INT RETAINING RING 22MM
1145	P07721145	LOCK WASHER 8MM
1146	P07721146	CAP SCREW M6-1 X 35
1147	P07721147	CAP SCREW M6-1 X 25
1148	P07721148	BALL BEARING 6900ZZ
1149	P07721149	BUBBLE BLADE GUARD

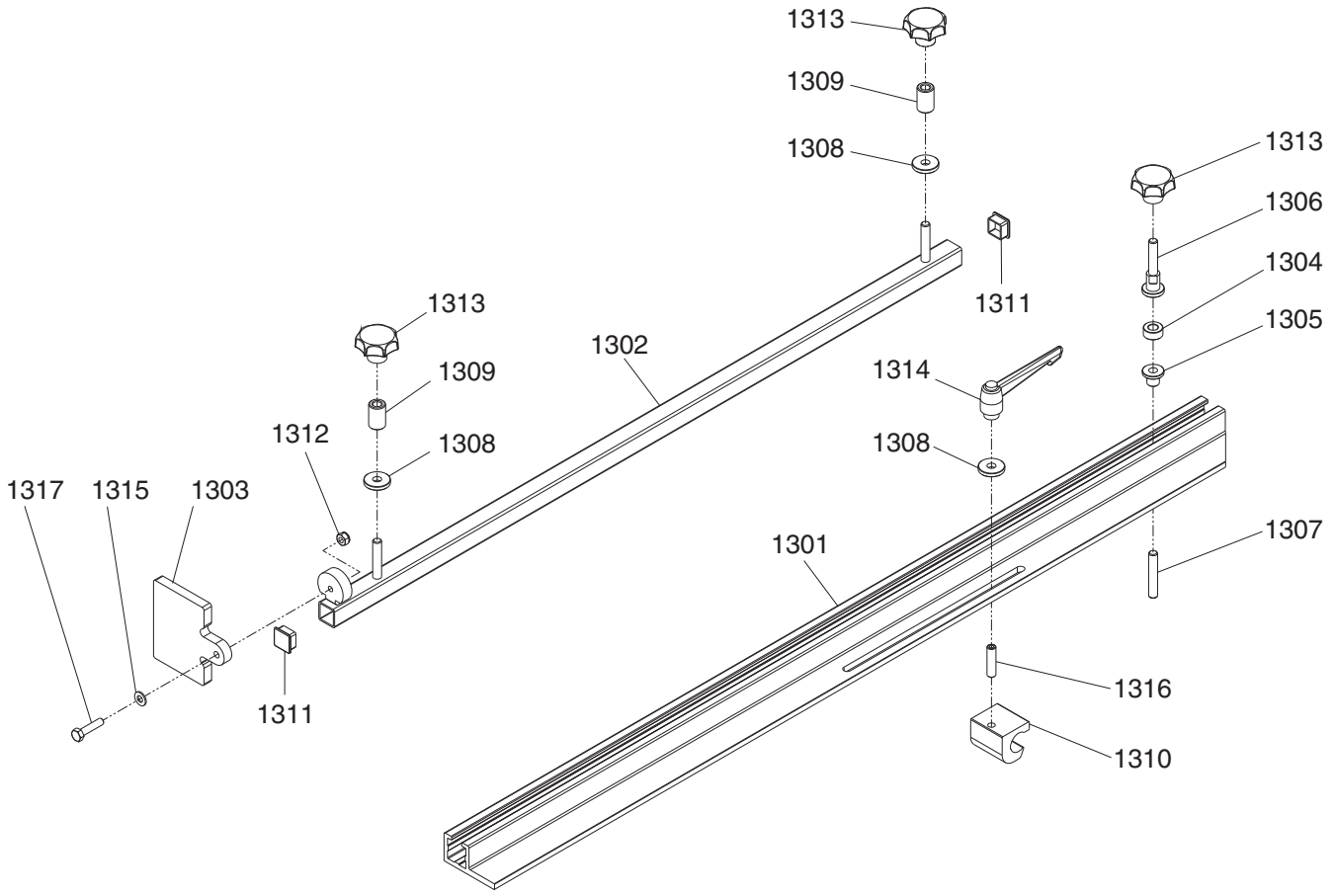
Blade Guard Arms



REF	PART #	DESCRIPTION
1201	P07721201	FIXED BASE
1202	P07721202	PIVOT BLOCK
1203	P07721203	BUSHING
1204	P07721204	LOCK SHAFT M10-1.5 X 50
1205	P07721205	GUARD ARM PIVOT BRACKET
1206	P07721206	SET SCREW M12-1.75 X 35 CONE-PT
1207	P07721207	ADJUSTMENT BLOCK
1208	P07721208	SET SCREW M12-1.75 X 50 CONE-PT
1209	P07721209	BLADE GUARD SWING ARM
1210	P07721210	UPPER SUPPORT ARM
1211	P07721211	LOWER SUPPORT ARM
1212	P07721212	KNOB M8-1.25 7-LOBE
1213	P07721213	LOCK NUT M12-1.75

REF	PART #	DESCRIPTION
1214	P07721214	HEX NUT M8-1.25
1215	P07721215	HEX BOLT M8-1.25 X 20
1216	P07721216	CAP SCREW M6-1 X 25
1217	P07721217	LOCK WASHER 6MM
1218	P07721218	SET SCREW M8-1.25 X 25
1219	P07721219	FLAT WASHER 6MM
1220	P07721220	FLAT WASHER 8MM
1221	P07721221	LOCK WASHER 8MM
1222	P07721222	CAP SCREW M8-1.25 X 16
1223	P07721223	CAP SCREW M8-1.25 X 30
1224	P07721224	LOCK WASHER 10MM
1225	P07721225	FLAT WASHER 10MM
1226	P07721226	HEX BOLT M10-1.5 X 25

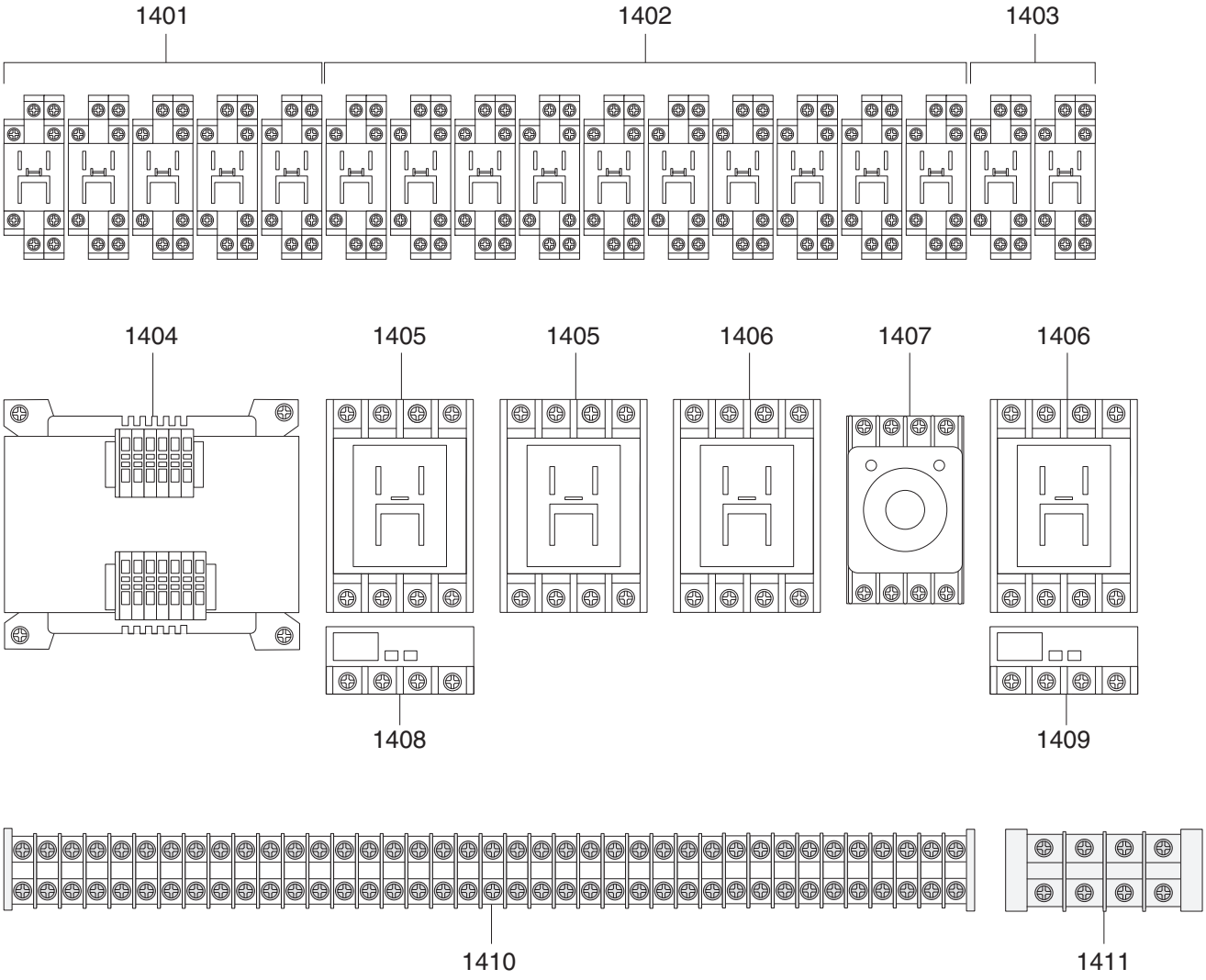
Miter Fence

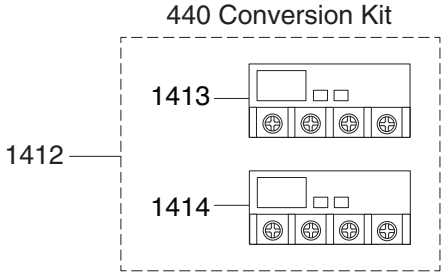


REF	PART #	DESCRIPTION
1301	P07721301	MITER FENCE
1302	P07721302	MITER FENCE EXTENSION ARM
1303	P07721303	MITER FENCE FLIP STOP
1304	P07721304	SPACER
1305	P07721305	POSITIONING RING
1306	P07721306	MITER LOCK SHAFT
1307	P07721307	SET SCREW M10-1.5 X 60
1308	P07721308	FENDER WASHER 10M X 5MM
1309	P07721309	LOCK COLLAR

REF	PART #	DESCRIPTION
1310	P07721310	C-FASTENING BLOCK
1311	P07721311	END-CAP 25 X 25MM
1312	P07721312	LOCK NUT M8-1.25
1313	P07721313	KNOB M10-1.5 7-LOBE
1314	P07721314	ADJUSTABLE HANDLE M10-1.5
1315	P07721315	FLAT WASHER 8MM
1316	P07721316	SET SCREW M10-1.5 X 40
1317	P07721317	HEX BOLT M8-1.25 X 35

Electrical Panel

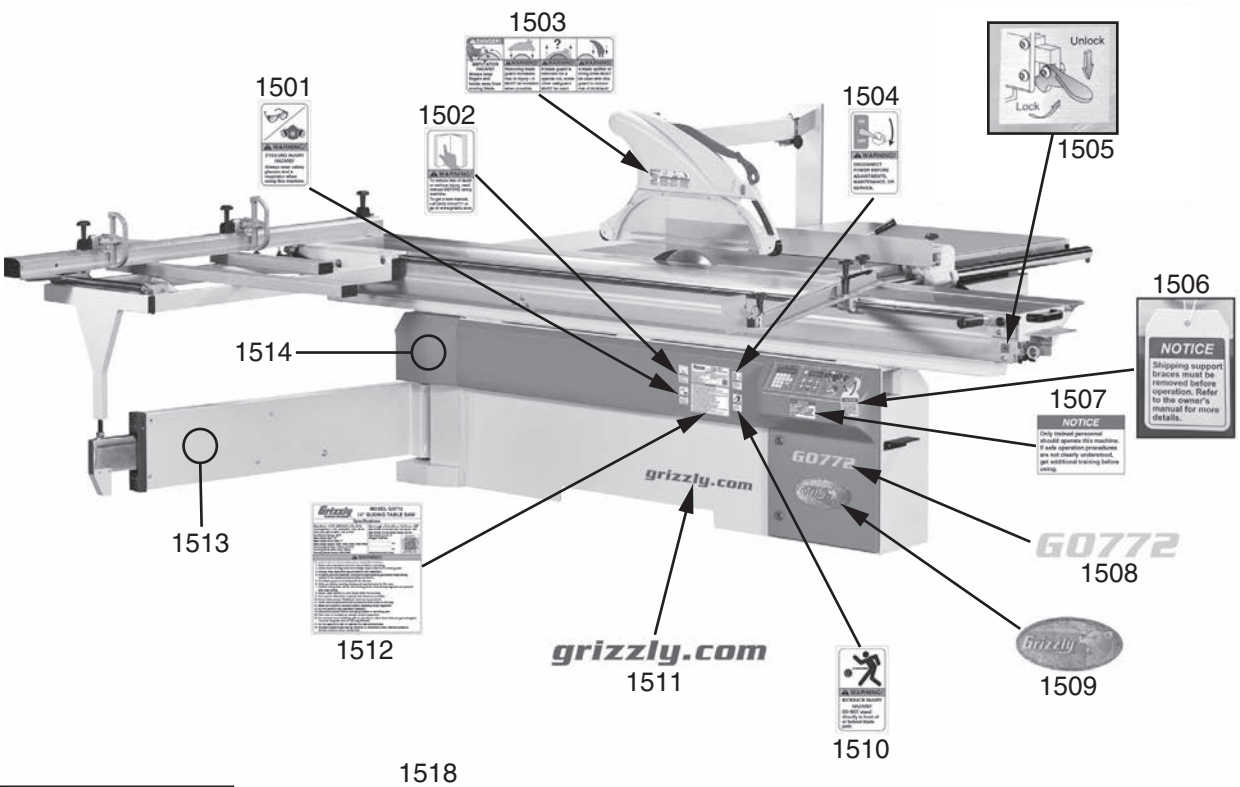


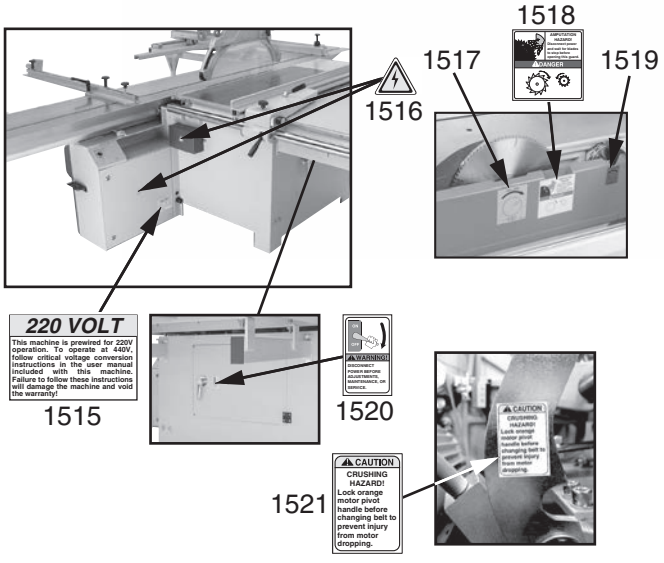


REF	PART #	DESCRIPTION
1401	P07721401	RELAY OMRON MY2N-J 24VDC
1402	P07721402	RELAY OMRON MY2N-J 220VAC
1403	P07721403	RELAY OMRON MY2N-J 120VAC
1404	P07721404	TRANSFORMER SHANG-YUE 200V
1405	P07721405	CONTACTOR TECO CU-16 3A1A 600V
1406	P07721406	CONTACTOR TECO CU-11 3A1B 600V
1407	P07721407	STAR-DELTA TIMER ANV CRD-N 250VAC 5A

REF	PART #	DESCRIPTION
1408	P07721408	OL RELAY TECO RHU-10/16K1 11.3-16A
1409	P07721409	OL RELAY TECO RHU-10/4K1 2.9-4A
1410	P07721410	TEMINAL BAR 39P
1411	P07721411	TEMINAL BAR 4P
1412	P07721412	440V CONVERSION KIT
1413	P07721413	OL RELAY TECO RHU-10/7.5K1 5.7-7.5A
1414	P07721414	OL RELAY TECO RHU-10/2K1 1.4-2A

Labels & Cosmetics



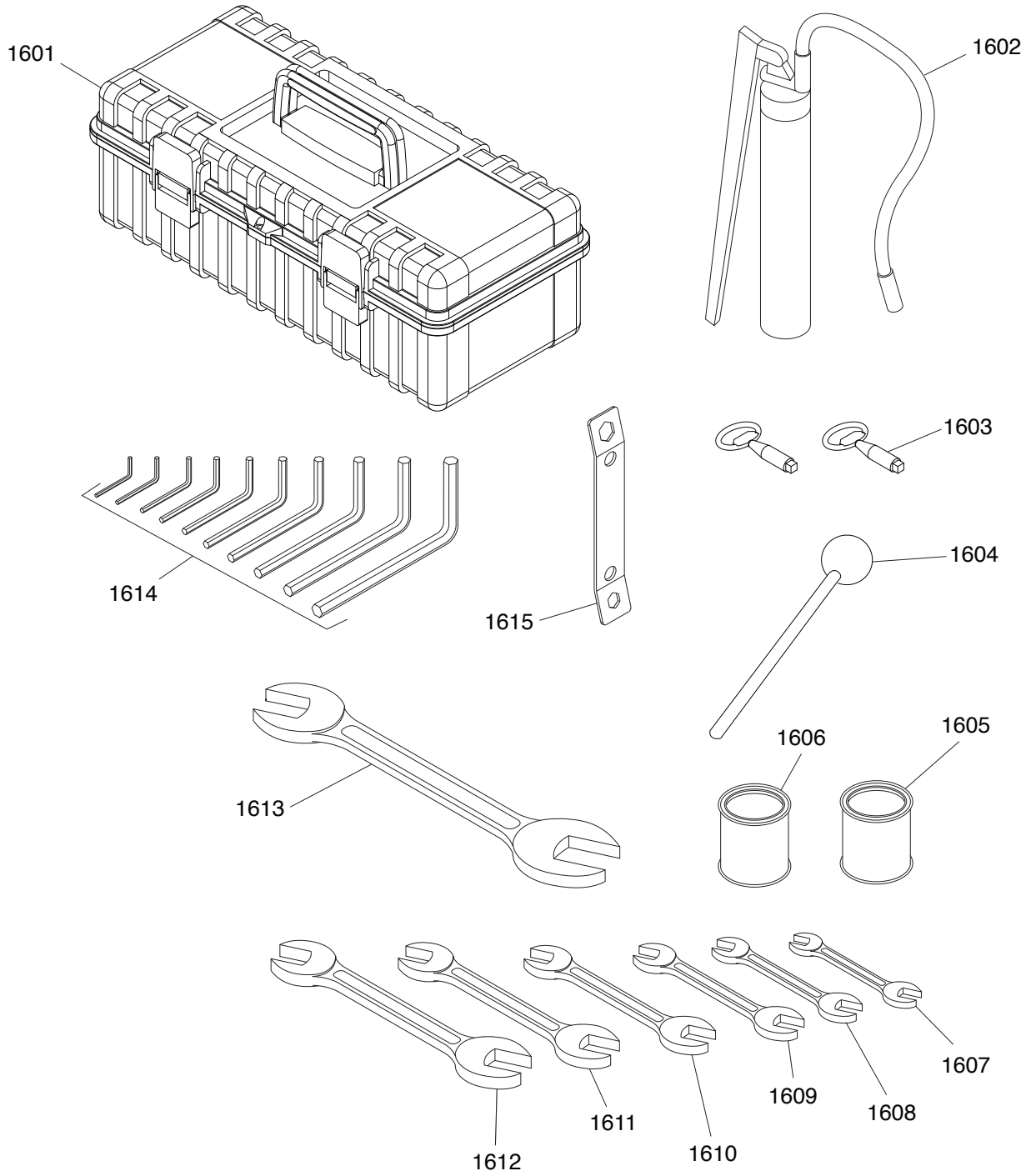


REF	PART #	DESCRIPTION
1501	P07721501	EYE/LUNG INJURY HAZARD LABEL
1502	P07721502	READ MANUAL LABEL
1503	P07721503	BLADE GUARD/RIVING KNIFE LABEL
1504	P07721504	DISCONNECT POWER LABEL
1505	P07721505	SLIDING TABLE LOCK LABEL
1506	P07721506	SUPPORT BRACE NOTICE
1507	P07721507	TRAINED PERSONNEL NOTICE
1508	P07721508	MODEL NUMBER LABEL
1509	P07721509	GRIZZLY NAMEPLATE
1510	P07721510	KICKBACK INJURY HAZARD LABEL
1511	P07721511	GRIZZLY.COM LABEL
1512	P07721512	MACHINE ID LABEL
1513	P07721513	GRIZZLY PUTTY TOUCH-UP PAINT
1514	P07721514	GRIZZLY GREEN TOUCH-UP PAINT
1515	P07721515	PREWIRED 220V LABEL
1516	P07721516	ELECTRICITY LABEL
1517	P07721517	MAIN BLADE ROTATION LABEL
1518	P07721518	AMPUTATION HAZARD LABEL
1519	P07721519	SCORING BLADE ROTATION LABEL
1520	P07721520	DISCONNECT POWER LABEL
1521	P07721521	CRUSHING HAZARD LABEL

⚠WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.

Accessories



REF	PART #	DESCRIPTION
1601	P07721601	TOOL BOX
1602	P07721602	GREASE GUN
1603	P07721603	CABINET KEYS
1604	P07721604	BLADE LOCKING TOOL
1605	P07721605	GRIZZLY GREEN TOUCH-UP PAINT CAN
1606	P07721606	GRIZZLY BEIGE TOUCH-UP PAINT CAN
1607	P07721607	WRENCH 8 X 9MM OPEN-ENDS
1608	P07721608	WRENCH 10 X 12MM OPEN-ENDS

REF	PART #	DESCRIPTION
1609	P07721609	WRENCH 12 X 14MM OPEN-ENDS
1610	P07721610	WRENCH 14 X 17MM OPEN-ENDS
1611	P07721611	WRENCH 17 X 19MM OPEN-ENDS
1612	P07721612	WRENCH 21 X 23MM OPEN-ENDS
1613	P07721613	WRENCH 30 X 41MM OPEN-ENDS
1614	P07721614	HEX WRENCH SET
1615	P07721615	SCORING BLADE WRENCH

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinetmaker & FDM
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____Yes _____No

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

grizzly.com®

TOOL WEBSITE

Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!

~Since 1983~

Visit Our Website Today For Current Specials!

ORDER

24 HOURS A DAY!

1-800-523-4777